Thursday, 09/08/2007 8:17:58 AM

User

Linda Lacelle

#### **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 33853

**Estimate Number** 

: 11383

P.C. Number This Issue

: NA

: 09/08/2007

Prsht Rev. First Issue

**Previous Run** Written By

Checked & Approved By

Comment

: Est. A 03.11.14

PURCHASED PARTS

New issue KJ/DS

S.O. No. : 1)A

**Drawing Name** 

: FLOAT ASSEMBLY

**Part Number** 

: U3218041 : D3218 REV B'C C 167-38-89 : N/A : B : N/A 24/08/2007 Otv.

**Drawing Number** Project Number

**Drawing Revision** 

Material **Due Date** 

Each

**Additional Product** 

Jot Number:



Seq. #:

**Machine Or Operation:** 

Description: PURCHASING

C207/08109(8)

1.0 PG



Comment: PURCHASING

Order bags in multiples of 3

Issue P/O: \_\_\_\_4\_328

Supplier: Tulmar Safety SystemsD3218-041 Float Assembly per Dwg D3218

Serial No.: BXXXXX-01, BXXXXX-02, etc.

Copy of inspection paperwork is required with each Float Assembly

2.0

D3218041P





Comment: Qty.:

1.0000 Each(s)/Unit Total:

8.0000 Each(s)



3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

Ensure inspection paperwork is provided with each Float Assembly

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Review vendor paperwork for completeness

Ensure all pressure tests passed Ensure all dimensions within tolerance Ensure Dart inspection performed

Ensure s/n printed on bag matches paperwork/Dart W/O

Visually inspect bag for defects

No de-lamination or puckering of seams



### **Dart Aerospace Ltd**

W/O:		WORK ORDER CHAN	IGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #: Fault Category:	NCR: Ye	es No DC	A:	Date: <u>&lt;</u>	571094a
			QA	: N/C Close	ed:	_ Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)												
		Description of NC		Corrective Action Section B	Verification	A	Approval QC Inspector							
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng		Sign & Date	Section C		Approval Chief Eng						

NOTE: Date & initial all entries

Date: User:

Thursday, 09/08/2007 8:17:58 AM

Linda Lacelle

**Process Sheet** 

PACKAGING RESOURCE #1

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT ASSEMBLY

Description:

Job Number: 33853

Part Number: D3218041

ob Number:



Seq. #:

**Machine Or Operation:** 

Girt attachment OK

No holes through stitching

No excess glue

Valves installed in proper locations

07.09.12

5.0

PACKAGING 1



Comment: PACKAGING RESOURCE #1

Re-package and Stock in Kwik Float cell

QC21 6.0



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion





U A.09.12

### Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES													
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector									
		-														
Part No	•	PAR #· Fault Category: No	P. Voc	: No DO	٨.	Date:										

Part No:	PAR #:	Fault Category:	NCR: Yes	No	DQA:	_ Date: _	
			QA: N	/C CI	losed:	_ Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)												
		Description of NC		Corrective Action Section E	Verification	Ammental	Approval							
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector						
						:								
								; 1						

NOTE: Date & initial all entries



DESIG	DS	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECK	(ED A	APPROVED /	DRAWING NO.	REV. C
	#	<b>₩</b>	D3218 SHEET	1 OF 2
 DATE			TITLE	SCALE
 04.1	2.01		FLOAT ASSEMBLY	NTS
Α		03.10.06	NEW ISSUE	
В		04.10.26	ADD BONDING/TESTING/MFG SPEC	
С		04.12.01	UPDATE NOTE #1, #2, & #4	



#### D3218-041 FLOAT ASSEMBLY, NOTES:

#### 1) MATERIAL:

ITEM	DESCRIPTION	QTY
FABRIC	POLYURETHANE COATED, PENNEL 987- 123 YELLOW	7.20 m
ADHESIVE	SEALREZ S-0345 A/B	2.50 L
WEBBING	LAGRAN #3003, 1" WHITE NYLON	0.31 m
THREAD	NYLON, TWISTED TYPE II, SIZE F, CLASS A, V-T-295, COLOR TAN	5.00 yds
NYLON CORD	MIL-C-5040 TYPE III, COLOR NATURAL	1.60 m
LETTERING	COATES SCREEN C99 S170 BLACK, HIGH GLOSS	0.50 oz
INFLATION VALVE	MIRADA B-51016 / A-51265	2
PRESSURE RELIEF VALVE	MIRADA B-51019	2
TOPPING VALVE	MIRADA B-51209	2
FLANGE	MIRADA B-51014-N (4.25")	4
FLANGE	HALKEY ROBERTS 981001020 (3.5")	2

- 2) ADHESIVE BONDING TO BE PERFORMED I.A.W. TULMAR PCS 002 REV. D USING AN ADHESIVE THICKNESS OF 0.008' +/- 0.003" (3 COATS). COUPON TESTING TO BE PERFORMED I.A.W. TULMAR PCS 006 REV. C. MANUFACTURING PROCESS IS DEFINED BY TULMAR PIF #193-8927 REV. E
- 3) AFTER MANUFACTURE:
  - (a) PRESSURE TEST EACH CHAMBER TO 4.36 PSI (30 kPa) FOR 5 MINS.
  - (b) INFLATE TO RELIEF VALVE PRESSURE [MIN OF 3.00 PSI (20.6 kPa)]. RELIEF VALVE MUST OPEN AT 3.3-3.5 PSI AND MUST CLOSE AT NOT LESS THAN 3.00 PSI. BAG MUST MAINTAIN A MIN PRESSURE OF 1.6 PSI (11.0 kPa) FOR 24 HOURS.
- 4) FLOAT IDENTIFICATION LETTERING 0.313" (7.95mm) HIGH BLACK CAPITAL LETTERS STENCILED ON THE R/H SIDE OF THE FLOAT BAG AS FOLLOWS:

DART AEROSPACE LTD. FLOAT ASSEMBLY P/N D3218-041 S/N BXXXXX-XX REPLACES HELITECH P/N 358-008-001 WWW.DARTAERO.COM

- 5) COATED SIDE OF FABRIC ON OUTSIDE OF BAG.
- 6) ALL DIMENSIONS ARE IN INCHES. CRITICAL DIMENSIONS (DENOTED BY 5) MUST BE OBTAINED AT 2 PSI.
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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0307108/09 001/08/09

#### PACKING SLIP

# ULMA.K

Tulmar Safety Systems Inc.

1123 Cameron Street Hawkesbury, ON K6A 2B8 CA

Tel: 613-632-1282 Fax: 613-632-2030 MID: CATULSAF1123HAW email: info@tulmar.com

Bill No:

**Dart Aerospace** 

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7. Canada

Ship To:

**Dart Aerospace** 

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7. Canada

613-632-3336

Order No.

Order Date

20153

10-Aug-07

**Customer PO Number** 

PO00004328

Item No. Description Customer No.

CDART100

Ship Via Pick-Up

EΑ

Barney Bangs PPD/COL

Sales Rep.

Release Note No.

Packing Slip No. 26809

Ship Date

17-Aug-07

R92-26809

8

MOU

Qty Shipped/Returned

8

**Qty Backordered** 

8927

Float Assembly, individual bag/P/N: D3218-041

Drawing No: D3218

Rev: C **Comments:** 

Serial No: B21829 00000013

Serial No: B21829 00000019

Serial No: B21829 00000016

Serial No: B21829 00000014

Serial No: B21829 00000017 Serial No: B21829 00000020

Serial No: B21829 00000015

Serial No: B21829 00000018

#### **RELEASE NOTE**

# ULMAR

Tulmar Safet / Systems Inc. 1123 Cameron Street

Hawkesbury, ON K6A 2B8 CA 613-632-1282 Tel: 613-632-2030 Fax:

www.tulmar.com email: info@tulmar.com

Sill No:

Dark Aerospace 1270 Aberdeen Street

∃awkesbury, ON K6A 1K7. Canada

Release Note No.

R92-26809

Ship Date

17-Aug-07

Ship To:

**Dart Aerospace** 

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7. Canada

613-632-3336

Order No.

**Order Date** 

Customer No.

Sales Rep.

20153

10-Aug-07

CDART100 Ship Via

Barney Bangs

**Customer PO Number** PO00004328

Pick-Up

Packing Slip No.

26809

Item No.

Qty

UOM

Oty Shipped/Returned

**Qty Backordered** 

Description

5927

8

EΑ

8

Float Assembly, individual bag/P/N: D3218-041

Drawing No: D3218

Rev: C

Comments:

Serial No: B21829 00000013

Serial No: B21829 00000014

Serial No: B21829 00000015

Serial No: B21829 00000016

Serial No: B21829 00000017

Serial No: B21829 00000018

Serial No: B21829 00000019

Serial No: B21829 00000020

If any questions or concerns, please contact QA Manager @, 613-632-1282 ext. 245

his release note is a Certificate of Conformance and I hereby certify that the items listed hereon have been inspected tested and conform to all specifications and requirement; detailed in the contract or purchase order Objective evidence to support this release note is on file and can be made available upon request

Authorized Inspector

08/17/2007

Date

#### RELEASE NOTE

# TULMAR

Tulmar Safety Systems Inc. 1123 Cameron Street Hawkesbury, ON K6A 2B8 CA

613-632-1282 Tel: Fax: 613-632-2030 www.tulmar.com email: info@tulmar.com

Bill No:

**Dart Aerospace** 

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7. Canada

Release Note No.

R92-26809 Ship Date

17-Aug-07

Ship To:

**Dart Aerospace** 

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7. Canada

613-632-3336

Order No. Order Date

Customer No.

Sales Rep.

20153

10-Aug-07

CDART100

Barney Bangs

Customer PO Number

Ship Via

Packing Slip No.

PO00004328

Pick-Up

26809

Item No.

Qty

Qty Shipped/Returned

**Qty Backordered** 

Description

8

EΑ

MOU

8

Float Assembly, individual bag/P/N: D3218-041

Drawing No: D3218

Rev: C **Comments:** 

8927

Serial No:

Serial No:

Serial No: B21829 00000013 B21829 00000016

B21829 00000019

Serial No:

Serial No: B21829 00000014

Serial No: B21829 00000017 B21829 00000020 Serial No:

B21829 00000015

Serial No: B21829 00000018

If any questions or concerns, please contact QA Manager @ 613-632-1282 ext. 245.

This release note is a Certificate of Conformance and I hereby certify that the items listed hereon have been inspected tested and conform to all specifications and requirements detailed in the contract or purchase order Objective evidence to support this release note is on fileand can be made available upon request

Authorized Inspector

08/17/2007

Date

#### **PACKING SLIP**

# ULM

Tulmar Safety Systems Inc.

1123 Cameron Street Hawkesbury, ON K6A 2B8 CA

Tel: 613-632-1282 Fax: 613-632-2030 MID: CATULSAF1123HAW email: info@tulmar.com

Bill No:

**Dart Aerospace** 

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7. Canada

Packing Slip No. 26809 Ship Date

17-Aug-07

Ship To:

**Dart Aerospace** 

1270 Aberdeen Street Hawkesbury, ON K6A 1K7. Canada

613-632-3336

Order No.

Order Date

20153

10-Aug-07

Customer PO Number

PO00004328

Item No.

Description

Customer No.

CDART100

Ship Via

Pick-Up

**MOU** 

Barney Bangs

Sales Rep. PPD/COL

Release Note No.

R92-26809

Qty Backordered

8927

EΑ

8

Qty Shipped/Returned

Float Assembly, individual bag/P/N: D3218-041

Drawing No: D3218

Rev: C Comments:

Serial No: B21829 00000013 Serial No: B21829 00000016

Serial No: B21829 00000019

Serial No: B21829 00000014

Serial No: Serial No: B21829 00000020

B21829 00000017

Serial No: B21829 00000015

Serial No: B21829 00000018

TI	71	1/	4R
IL	L.	IVII	AL

Rev.	D	Sheet	1/

Description: Float Bag Assembly S/N: B21829-13

5/0: 20153 S/Fioder:41	TSS P/N: <u>89</u>	<u>227</u> Qty.: <u>1</u>	Customer P/N: <u>D</u>	3218-041	Dwg. No.: <u>D3218</u>	Rev.: A Date:	
Cutting I	AW PCS 003	Markin	g IAW PCS 004	Bono	ling IAW PCS 002	∠ Sm,	Silkscreen
Operator No.	Date	Operator No.	Date	Operator No.	Date	Operator No.	Date
				(Docu	mented below	)	
				`		,	

No. + Date Accept. Stamp Otv. Otv. 1- a) a) Attach Panel A (uneven edge) to larger edge of Panel B. centered on a 2" inner tape (butt joint)± 1/8" b) Attach (6) Valve Flanges on Panel A: 2-Relief, 2-Inlet & 2- Topping Up c) Attach (6) Doublers on above Flanges Bonding 2- a) Attach Panel C to Straight edge of Panel A, centered on a 2" inner Tape (butt joint) ± 1/8" a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape 4- a) Baffle Ass'y, with 2" Tape  $\pm 1/8$ " Bonding 5- a) Attach Baffle Ass'y. to Bag (in 3 stages, minimum) Testing a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time (see sheet 2) 7- a) Closure of 1" Main Seam (overlap) ± 1/8" Bonding b) Attach ID Patch (ref. CAR 04-003) Testing 8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time (see sheet 2) 9- a) Attach 1" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8" Bonding b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bag c) Attach 5" split patch on each end (x 4)

Rev. D Sheet 2/3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date
10- a) Final Test b) Inspector to Stamp on ID Patch: Serial No.: B 2 / 829 - / 3	12	Testing	].	factoria.		1	(388) (A)	aug 15/07
& Inspection Stamp beside the S/N		(see sheet 3)						

Upon completion of the (final) leakage test, the ID Patch shall be stamped with 5/16 " high lettering and black ink: scrial number (7 digits), provided by DART (refer to W/O). \* Verify the integrity of the Valves (Threads/gaskets)

**Test Conditions** – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

#### Baffle Test:

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams:

Inflation Test: Lower Chamber to 3.00 psi; re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase

+ 0.054 PSI for each 1°C of temperature decrease

+ 0.049 PSI for each 0.1 inch of barometric increase

- 0.049 PSI for each 0.1 inch of barometric decrease

Chambers	Draggues	5 Min. Over P. & Soap Test	li .	45 Minute bilizing Per							l Ho	ur Test			
# 1	Pressure	Pass / Fail	Design Pressure (1246/0/07	Time On	Time Off	Design Pressure	Time On	Time Off	Read'g	1	mp. E/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail
# 1 (see note 1)	4.36 PSI		3.00	1045	11:30	3.00 PSI	11:30	12:30	3.00 PSI	25	25	29.77 29.77		3.00 PSI	Pass
Re-Test			aug13/67								1				
# 2 (Main Seam)	4.36 PSI		3.00 PSI	8:25	91.10	3.00 PSI	9:15	10:15	3.00 PSI	23	23	29.75 29.75		3.ひひ PSI	Ress
Re-Test											1			·	

Note 1: Chamber # 1 requires Dart Aerospace Approval Signature:	n/a	Date: Na
Observations:	1	· /

## 5/N; B 2 1829-13 Product Inspection Form # 193-8927 (Tube & Final)

Rev. D Sheet 3/3

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 – 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the dhamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief		0	pening		(	и <u>35/6</u>		
Valve Test	PRV Serial Numbers	Time ON	Pressure		Time	Close		Pass / Fail
Chamber # 1	33196	10:50	3.18	PSI	10:55	3,06	PSI	Pasa
Chamber # 2 (Main Seam)	33714	111:55	3.50	PSI	12:00	3.14	PSI	fass

Chambers	Design				24 Hour L	eakage Test			
aug/307	(closing) Pressure as per above	Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail
#1	3.06 PSI	10:55	10:55	2.66 PSI	24 23	29.74 29.86	0.054	2.79 PSI	Pass
Re-Test						:			
(Main Seam)	3.14 PSI	12:00	13:00	2.45 PSI	33 23	29.86 29.63	G. 112	2.38 PSI	fass)
Re-Test									

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	V	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	± 0.100 *			47.0	± 0.5				24.75	± 0.5		
7.3	± 0.100 *			* = I	AW OSI 018.		Adated 03-05-29	•	31.0	± 0.5		
					<b>(</b> ,		No					

`

#### Submission of Adhesive Testing

		Subm.Date / am-pm	Pass/Fail						
	24 hour								
ď	7 day				(0//-1				
r a	24 hour				10/0				
She	7 day								



		_		
Rev	D	Shee	t 1	1

#

**Description**: Float Bag Assembly

-Items are Manufactured IAW Process Control Specification No. 001, 002, 003, 004, 005, 006, and are to be 100% inspected I.A.W. P.I.P. 001

w/o:<u>4114</u>

TSS P/N: 8927

Qty.: 1

Customer P/N: <u>D3218-041</u>

Dwg. No.:D3218

Rev.: A

Date:

Cutti	ng IAW PCS 003	Mark	ing IAW PCS 004	Bond	ing IAW PCS 002	Silkscreen		
Operator No.	Date	Operator No.	Date	Operator No.	Date	Operator No.	Date	
					·			
				( Docui	nented below)			

<sup>\*</sup> Note: PCS 006, there shall be a total of 2 samples submitted for the Testing of the Adhesive (Peel and Shear Test), at start and end of every production day, record on sheet 3/3

Stages & Descriptions	Operator	Operation	Accept.	Reject.	NCR	Total	Insp.	Date
	No. + Date		Qty.	Qty.		Accept.	Stamp	
1- a) a) Attach Panel Λ (uneven edge) to larger edge of Panel B, centered on a 2" inner tape (butt joint)± 1/8"	Chantal 156 9 Feu. 05		1			1	(25)	Feb. 9/05
b) Attach (6) Valve Flanges on Panel A: 2-Relief, 2-Inlet & 2- Topping Up	Helexe 117 8 Lev 05	Batch 7122	6			6		Feb 9/05
c) Attach (6) Doublers on above Flanges	8 Few 05	Bonding	6			6	11)	Feb 9/05
2- a) Attach Panel C to Straight edge of Panel A, centered on	Chantal 156	7111 28	1			1	1.8 8	Feb. 9/05
a 2" inner Tape (butt joint) ± 1/8"	PFév 05					•	(4s)	
3- a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape	arontal 156	7104-28	l			1	(9)	Feb. 9/05
4- a) Baffle Ass'y. with 2" Tape ± 1/8"	1011anne 110 9/02/05	7104	1		.—	1	6211	Feb 9105
5- a) Attach Baffle Ass'y. to Bag ( in 3 stages, minimum )	H110 10102105	Bonding 28	1		_		77	Feb10/05
6- a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time	10/03/05 12 22/naujos	Testing (see sheet 2)	1		_	(	(B.5)	Mars/22/05
7- a) Closure of 1" Main Seam (overlap) ± 1/8"	21 HOUR OF	Bonding			_	1	18.00	april 28/05
b) Attach ID Patch (ref. CAR 04-003)	#110 3 Mar/05	A	. 1				X#	May 5/05
8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time	12 / 26/0pil /05	Testing (see sheet 2)	,				4	amil/26/05
9- a) Attach 1" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8"			1			1		May 4/05
b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bag	03/05/05	Bonding	1		_	1 1	133	Mby 4/05
c) Attach 5" split patch on each end (x 4)	110 09/05/05	29	/			/	91/	May 4/05

Rev. D Sheet 2/3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date
10-° a) Final Test			WA WILL P					
b) Inspector to Stamp on ID Patch:		Testing						
Serial No.: <b>B</b>		(see sheet 3)						
& Inspection Stamp beside the S/N							,	
		<del></del>	<u> </u>	J	L	· · · · · · · · · · · · · · · · · · ·		

Upon completion of the (final) leakage test, the ID Patch shall be stamped with 5/16 " high lettering and black ink; serial number (7 digits), provided by DART (refer to W/O). \* Verify the integrity of the Valves (Threads/gaskets).

**Test Conditions** – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

#### Baffle Test:

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams. Inflation Test: Lower Chamber to 3.00 psi, re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase
- + 0.054 PSI for each 1°C of temperature decrease
- + 0.049 PSI for each 0.1 inch of barometric increase
- 0.049 PSI for each 0.1 inch of barometric decrease

Chambers	Pressure	5 Min. Over P. & Soap Test		45 Minute bilizing Per	i					Hlo	ur Test		humy	11%.
Chambers	riessuic	Pass / Fail	Design Pressure	Time On	Time Off	Design Pressure	Time On.	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail
# 1 (see note 1)	4.36 PSI	Pasa	3.00 PSI	7:55	8:4c	3.00 PSI	8:40	9:40	3.200 PSI	33' 33	29.94 29.94	-/	3.00 PSI	Pass
Re-Test											1.		hung	22 %
# 2 (Main Seam)	4.36 PSI	Pass	3.00 PS1	9:20	10:00	3.00 PSI	10:00	11:00	3.05 PSI	22 23	29.62 29.62	-0.054	<b>2.99</b> PSI	Pass
Re-Test		<i>č</i> .												

Note 1: Chamber # 1 requires Dart Aerospace Approval Signature:	Can Down	Date: 05.04.18
Observations: OK		

Rev. D. Sheet 3/3

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 - 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief		Ор	ening	Clos	ing	
Valve Test	PRV Scrial Numbers	Time ON	Pressure	Time [	Close	Pass / Fail
Chamber # 1	33196	9:40	3,44 PSI	9:45	3.19 PSI	Pago
Chamber # 2 (Main Seam)	337/4	10:40	3.34 PSI	10:45	3.06 PSI	Pass

Chambers	Design			hume 18	<sup>6</sup> /0				
	(closing) Pressure as per above	17 1		Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Readig	Pass Fail
# 1 Rc-Test	3.19 PSI	9:45	9:45	2.63 PSI	24" 21"	30.07 30.34	40.132	2.92 PSI	Pass
# 2 (Main Scam)	3.06 PSI	10:45	10:45	2.48 PSI	aa* 23°	30.34 30.15	-0.054	2.34 PSI	Pass)
Re-Test									

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass Fail
3.5	上 0.100 *	3.4	Pass	47.0	± 0.5	46 5/8	Pass	24.75	± 0.5	<i>35</i> "	Pasa
7.3	± 0.100 *	7.3	Pass	* = IAW	/ OSI 018. rev	v. A dated 03-05-29	122	31.0	+ 0.5	31 1/4 "	Pass
					<b>4</b>	(	<b>.</b>				

### Submission of Adhesive Testing:

		Subm.Date/mpm	Pass/Fail	Subm.Date / am-on	Pass/Fail	Subm.Date/@pm	Pass/Fail	Subm.Date @pm	Pass/Fail
ee	24 hour	Jeb 8/05	Pasa	Jeh 9/05	Pass	april 24/65	Pass	may 3/05	Paso
<u> </u>	7 day	Jeb 8/c5	Pass	Ach 9/05	Para	april 29/05	Pass	. / / -	Pass
ear	24 hour	Feb 8/05	Pass	Jes 9/05	Pass	aprie 29/05	Pass.	may 3/05	pras
Sh	7 day	Ach 8/05	Pass	Get 4/05	fues	april 29/05	Pass	May 3/05	Pass

Rev. D Sheet 1/3

<b>Description:</b> Float Bag Assembly	5/N:	B21829-14
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-Items are Manufactured IAW Process Control Specification No. 001, 002, 003, 004, 005, 006, and are to be 100% inspected I.A.W. P.I.P. 001

S/0: 20153 TSS P/N: 8927 **Customer P/N: D3218-041** Dwg. No.:D3218 Date: Qty.: <u>1</u> 15 oden: 4114 Cutting IAW PCS 003 Silkscreen Marking IAW PCS 004 **Bonding IAW PCS 002** Operator No. Operator No. Date Date Date Date Operator No. Operator No. (Documented below

\* Note: PCS 006, there shall be a total of 2 samples submitted for the Testing of the Adhesive (Peel and Shear Test), at start and end of every production day, record on sheet 3/3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date
<ul> <li>1- a) a) Attach Panel A (uneven edge) to larger edge of Panel B, centered on a 2" inner tape (butt joint)± 1/8"</li> <li>b) Attach (6) Valve Flanges on Panel A: 2-Relief, 2-Inlet &amp; 2- Topping Up</li> <li>c) Attach (6) Doublers on above Flanges</li> </ul>		Bonding	,	-				·
2- a) Attach Panel C to Straight edge of Panel A, centered on a 2" inner Tape (butt joint) ± 1/8"								
3- a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape								
4- a) Baffle Ass'y. with 2" Tape ± 1/8"		•						
5- a) Attach Baffle Ass'y. to Bag (in 3 stages, minimum)		Bonding						
6- a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time		Testing (see sheet 2)						
7- a) Closure of 1" Main Seam (overlap) ± 1/8" b) Attach ID Patch (ref. CAR 04-003)		Bonding						
8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time		Testing (see sheet 2)						
9- a) Attach 1" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8"								
b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bag		Bonding						
c) Attach 5" split patch on each end (x 4)								

Rev. D Sheet 2/3

	Qty.	Qty.	NCR.	Accept.	Stamp	, Date
Testing					489)	aug 152007
(see sheet 3)	l		-	/	1 6	,30
-	Testing (see sheet 3)					

**Test Conditions** – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

#### Baffle Test:

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams. Inflation Test: Lower Chamber to 3.00 psi; re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase
- + 0.054 PSI for each 1°C of temperature decrease
- + 0.049 PSI for each 0.1 inch of barometric increase
- 0.049 PSI for each 0.1 inch of barometric decrease

Chamban	D	5 Min. Over P. & Soap Test	& Soap Test Stabilizing Period I Hour Test  Sure  Pass / Fail Design Time On Time Design Time On Time Temp. Baro		ur Test		,								
Chambers	Pressure		Design Pressure		Time Off	Design Pressure	Time On	Time Off	Read'g	Ter Start		Barom. Start/End	Adjust.	Final Read'g	Pass / Fail
# 1 (see note 1)	4:36 PSI		3.00		11:30	3.00 PSI	11:30	12:30	3 00 PSI	25	25	29.77 29.77	7_	3.00 PSI	Coss
Re-Test			244 13/07		•									-	
# 2 (Main Seam)	4.36 PSI		3.00 PSI	8:25	9:10	3.00 PSI	9:15	10:15	3.00 PSI	23	23	29.75 29.75		ا S. که ا PSI	Pass
Re-Test							-								

Note 1: Chamber # 1 requires Dart Aerospace Approval Signature:	Na	_ Date:_	Na.
Observations:	•		

# TULMAR #2 SIN: B21829-14

### **Product Inspection Form # 193-8927(Tube & Final)**

Rev. D Sheet 3/3

Final Test: Leakage / Reliet Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 – 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief		Оро	ening	CI	d 33%	
Valve Test	PRV Serial Numbers	Time ON	Pressure	Time Close		Pass / Fail
Chamber # 1	33199	10:55	3.45 PSI	11:00	3.24 PSI	Pass
Chamber # 2 (Main Seam)	33722	12:00	3.30 PSI	12105	3.00 PSI	Russ

Chambers	Design		24 Hour Leakage Test										
aug 13/0)	(closing) Pressure as per above	Time On Time Off		Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail				
# 1	3.24 PSI	11:00	. //:00	2.72 PSI	24 23	29.74 29.86	0.0588	2.83 PSI	Ros				
(Main Seam)	3.00 PSI	12:05	12:05	2.29 PSI	23 23	29.86 29.63	0.112	2.18 PSI	Pass				

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.		Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	± 0.100 *			47.0	± 0.5			`	24.75	± 0.5		
7.3	± 0.100 *			* = IA\		v. A	dated 03-05-29 V	(C)	31.0	± 0.5		

#### Submission of Adhesive Testing

	1	Subm.Date / am-pm	Pass/Fail						
	24 hour		1				-		
Ä	7 day					n)/a>			
ar	24 hour								
She	7 day							·	

## TULMAR

### **Product Inspection Form # 193-8927(Tube & Final)**

Rev. D Sheet 1/3

#2

**Description**: Float Bag Assembly

-Items are Manufactured IAW Process Control Specification No. 001, 002, 003, 004, 005, 006, and are to be 100% inspected I.A.W. P.I.P. 001

w/o: 41/4

TSS P/N: 8927

**Qty.: 1** 

Customer P/N: <u>D3218-041</u>

Dwg. No.: <u>D3218</u>

Rev.: A

ate:\/\below

ib /05

	IAW PCS 003	Marking I	AW PCS 004	Bonding	IAW PCS 002		Silkscreen
Operator No.	Date	Operator No.	Date	Operator No.	Date	Operator No.	Date
	· · · · · · · · · · · · · · · · · · ·						
				( Docum	ented below)		
				1		i I	

\* Note: PCS 006, there shall be a total of 2 samples submitted for the Testing of the Adhesive (Peel and Shear Test), at start and end of every production day, record on sheet 3/3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	ŃĊR	Total Accept.	Insp.	Date
1- a) a) Attach Panel A (uneven edge) to larger edge of Panel B, centered on a 2" inner tape (butt joint)± 1/8"	156 9 Février	potovi i	^			1		Je69/05
b) Attach (6) Valve Flanges on Panel A: 2-Relief, 2-Inlet & 2- Topping Up	117	Botch 28	6			6	(II)	Feb 9/05
c) Attach (6) Doublers on above Flanges	8+20-	Bonding	(e)			6	11)	Feb 9/05
2- a) Attach Panel C to Straight edge of Panel A, centered on a 2" inner Tape (butt joint) ± 1/8"	156 10 feturier	Batch 7109	/	·	_	/	(Si	Fab 10/05
3- a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape	156 10 dévoier	7104-28	/			/	(11)	Feb10/05
4- a) Baffle Ass'y. with 2" Tape ± 1/8"	110' 10Fev. 05	7/84.	1			/	45	Feb10/05
5- a) Attach Baffle Ass'y. to Bag (in 3 stages, minimum)	IIO Il Fev. oc	Bonding 28	./	-		/		Feb14/05
6- a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time	12 21 mars 05	Testing (see sheet 2)	1	<u>Mari</u>	_	1 .	(38)	Mars 21/05
7- a) Closure of 1" Main Seam (overlap) ± 1/8"	21 grill	Bonding	1	-	_	1		May 2/05
b) Attach ID Patch (ref. CAR 04-003)	5/5/05	29	(					may 9/05
8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time	3 may 2005	Testing (see sheet 2)	l	·	_	1	4	May 3/05
9- a) Attach 1" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8"	4May 05	- 1104-29	/		-	1	1.8.8	
b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bag	4 Mai 05	Bonding	1				(9)	May 9/05
c) Attach 5" split patch on each end ( x 4 )	yman a		1		_	1		

Rev. D Sheet 2/3

Stages & Descriptions	Operation No. + Date Operation	Accept. Qty.	Reject. Qty.	NCR.	Total Accept.	İnsp. Stamp	Date
10- a) Final Test b) Inspector to Stamp on ID Patch:	Testing						
Serial No.: B	(see sheet 3)						
Upon completion of the (final) leakage test, the ID Patch shall be stamped with 5/16 " hig	h lettering and black ink: serial number (7 d	igits), provided	by DART (refe	er to W/O). *	Verify the int	egrity of the V	alves (Threads/gaskets).

**Test Conditions** – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

#### Baffle Test:

Over Pressure: Using socket tool and torque wrench s/n.0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams. Inflation Test: Lower Chamber to 3.00 psi; re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase

- + 0.054 PSI for each 1°C of temperature decrease
- + 0.049 PSI for each 0.1 inch of barometric increase 1
  - 0.049 PSI for each 0.1 inch of barometric decrease

Chambers	Pressure	5 Min. Over P. & Soap Test		45 Minute bilizing Per						1 Ho	ur Test	hun	ا'دا ب	6
Chambers	, i ressure	Pass / Fail	Design Pressure	Time On	Time Off	Design Pressure	Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End		Final Read'g	Pass / Fail
# 1 (see note 1)	4.36 PSI	Pass	3.00 PSI	2145	3:30	3.00 PSI	3:30	4/30	3.00. PSI	24 24	29.79 29.79		3. vo PSI	Pasa
Re-Test														
# 2 (Main Seam)	4.36 PSI	Pass	3.00 PSI	9.35	/o:20	3.00 PSI	10:20	11:20	3.00 PSI	23 23	29.77 29.78	+0.004	<i>3.00</i> PSI	Pass
Re-Test													_	

Note 1: Chamber # 1 requi	res Dart Aerospace Approval Signa	iture: Chm H	monul	Date:	05.04.18
Observations:	MINOR BUBBLES OWN LOO	UMTION -> GLUE L	wanow		<del></del>

Rev. D Sheet 3/3

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 – 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief		Ope	ning	Clo		
Valve Test	PRV Serial Numbers	Ţime ON	Pressure	Time	Close	Pass / Fail
Chamber # 1	33199	3:15	3,39 PSI	3:20	3.08 PSI	Pass
Chamber # 2 (Main Seam)	33722	4:00	3.25 PSI	4505	3.01 PSI	Pass

Chambers	Design				24 Hour L	eakage Test			
Chambers	(closing) Pressure as per above	Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail
# 1	3.08 PSI	3:20	3:20	2.75 PSI	as as	29.83 29.64	- 0.093	2.65 PSI	Pass
Re-Test						;			
# 2 (Main Seam)	3.01 PSI	4:05	4/05	2.30 PSI	as as	29.64 29.65	+0.004	2.31 PSI	Pass
Re-Test									

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	± 0.100 *		Pass	47.0	± 0.5	46 3/4	Assi	24.75	± 0.5	251/4	Pass
7.3	± 0.100 *	7.3	Foos	* = IAW	OSI 018 re	v. A dated 03-05-29	7× 55	31.0	± 0.5	313/8	Pass
					<b>Q</b> 5. 0.0, 10		( A )				

#### Submission of Adhesive Testing:

		Subm.Date / am	Pass/Fail	Subm.Date/am-pm	Pass/Fail	Subm.Date / am-ph)	Pass/Fail	Subm.Date/@pm	Pass/Fail
eel	24 hour	Feb 8/05	Pass	7eb10/05	Pass	may 3/05	Pass	may 4/05	Pass
<u> </u>	7 day	Feb 8/05	Pass	7 ch 10/05	faso	May 3/05	Pass	may 4/05	Pass
ä	24 hour	7eh 8/05	Pass	Jeb 10/05	Puss	may 2/05	Pass	may 4/05	Paso
She	7 day	Feb 8/05	Pess	Jeb 10/65	Pasa	May 3/05	Pass	may 4/05	Pass

Rev. D Sheet 1/3

**Description**: Float Bag Assembly 5/N: B21829-15

-Items are M	Ianufactured IAW P	rocess Control Spec	ification No. 00	01, 002, 003, 004,	005, 006,	and are to	be 10	0% inspecte	d I.A.W.	P.I.P. 001	 I
10: WO: 20153	TSS P/N: 892		Customer P/N:		Dwg. No	· <del>- · · - · · - · · · · · · · · · · · ·</del>	Rev.				
Fodon: 4/14 Cutting IA	1							C 3n.			
Cutting IA	W PCS 003	Marking IA	W PCS 004	Bon	ding IAW l	PCS 002			Silkscre	en 🦂	1. 2. 9546 14. 31.47.49
Operator No.	Date	Operator No.	Date	Operator No.		Date		Operator No.		Date	
		· ·		( Doci	<u>umentec</u>	l below	)				
			**************************************								
Note: PCS 006, the	re shall be a total of 2 sa	imples submitted for th	ne Testing of the A	Adhesive (Peel and	Shear Test	), at start ar	nd end o	of every produ	ction day,	record on	sheet 3/
Stages & Desc	riptions		Operator	Operation	Accept.	Reject.	NCF	Total	Insp.	Dat	te
b) Attach (6) Va 2-Relief, 2-Inl c) Attach (6) Doo 2- a) Attach Panel	el A (uneven edge) to large?" inner tape (butt joint)± lve Flanges on Panel A: let & 2- Topping Up ublers on above Flanges  I C to Straight edge of lape (butt joint) ± 1/8"	: 1/8"	No. + Date	Bonding	Qty.	Qfy		Accept.	Stamp		
3- a) Att. Panel D	to Panel B (shorter edge	e) with 2" inner Tape									
4- a) Baffle Ass'y	v. with 2" Tape ± 1/8"			D.22.10					,		
5- a) Attach Baffl	e Ass'y. to Bag (in 3 s	tages, minimum		Bonding	•						
6- a) Perform Baffl	e Test on Chamber # 1 af	ter a 3 day Cure Time		Testing (see sheet 2)							
•	" Main Seam (overlap) atch (ref. CAR 04-003			Bonding				,			
8- a) Perform Baffle	e Test on Chamber # 2 af	ter a 3 day Cure Time		Testing (see sheet 2)							
Seam, Cent				Bonding							
b) Att. Inspecte	ed Girt Ass'y. (Form 19	93-8927, Girt) to Bag		Donaing						ş	
c) Attach 5" sp	lit patch on each end (	x 4)									

Rev. D Sheet 2/3

Stages & Descriptions	Operator No. + Date	Operation Accept. Qty.	Reject. Qty.	NCR,	Total Accept.	Insp. ? Stamp	Date
10- a) Final Test b) Inspector to Stamp on ID Patch: Serial No.: B 2 1829 - 15 & Inspection Stamp beside the S/N	12	Testing (See Sheet 3)			1	ASS	aug 16/07

Upon completion of the (final) leakage test, the ID Patch shall be stamped with 5/16 " high lettering and black ink: serial number (7 digits), provided by DART (refer to W/O). \* Verify the integrity of the Valves (Threads/gaskets).

**Test Conditions** – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

#### Baffle Test:

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams. Inflation Test: Lower Chamber to 3.00 psi; re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase.

- + 0.054 PSI for each 1°C of temperature decrease
- + 0.049 PSI for each 0.1 inch of barometric increase
- 0.049 PSI for each 0.1 inch of barometric decrease

		5 Min. Over P. & Soap Test	El .	45 Minute bilizing Per												
Chambers	Pressure	Pass / Fail	Design Pressure	Time On	Time Off	Design Pressure	Time On	Time Off	Read'g	1	emp. t/End		om. /End	Adjust.	Final Read'g	Pass / Fail
# 1 (see note 1)	4.36 PSI		3.00	10:45	11:30	3.00 PSI	<i>]]:3</i> 0	1 <b>)</b> :30	3.00 PSI	25	25	2977	29.77		3.00 PSI	Ess
Re-Test			ena 13/07										† † †			
# 2 (Main Seam)	4.36 PSI		3.00 PSI	8:25	9:10	3.00 PSI	9:15	10:15	3,00 PSI	23	23	29.75	29.75		ろい PSI	Pos
Re-Test																·

Note 1: Chamber # 1 requires Dart Aerospace Approval Signature:	N/w	Date: N/c
Observations:	<i>,</i>	,

## TULMAR #3

S/N: B21829-15

### Product Inspection Form # 193-8927(Tube & Final)

Rev. D Sheet 3/3

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 – 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief		0	pening		C	Closing	Arumy 3376
Valve Test	PRV Serial Numbers	Time ON	Pressure		Time	Close	Pass / Fail
Chamber # 1	3.37/8	1/:00	3.30	PSI	11:05	3.02	PSI Pass
Chamber # 2 (Main Seam)	· 33721	12:05	3.26	PSI	12:10	3.08	PSI fass

Chambana	Design				24	Hour L	eakage Test				
Chambers	(closing) Pressure as per above	Time On	Time Off Read'g		Tem Start/	•	Bar Start	om. /End	Adjust.	Final Read'g	Pass / Fail
# 1	3.03 PSI	<i>) :3</i> 0	11:00	2.58 PSI	24	<i>3</i> 3	29.74	29.86	0.054	2.69 PSI	Russ
Re-Test								1			
(Main Seam)	,3.08 "SI	12:10	12:10	2.38 PSI	23	<i>a</i> 3	29.86	29.63		2.27 PSI	Pass
Re-Test				,							

$\begin{array}{c ccccccccccccccccccccccccccccccccccc$	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Di	im.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
72 +0100*	3.5				47.0	± 0.5				24.75	± 0.5		
* = IAW OSI 018, rev. A dated 03-05-29 $\triangle$ 1/ $\triangle$	7.3	± 0.100 *			* = IA	W OSI 018, re	v. A dated 03-0	15-20	NIW	31.0	± 0.5		

#### Submission of Adhesive Testing

		Subm.Date / am-pm	Pass/Fail						
<u>=</u>	24 hour								
a a	7 day	·	·	·		Was			
är	24 hour					/			
She	7 day						-	<u></u>	

Rev. D Sheet 1/3

#	3
. 1.	_

**Description**: Float Bag Assembly

-Items are Manufactured IAW Process Control Specification No. 001, 002, 003, 004, 005, 006, and are to be 100% inspected I.A.W. P.I.P. 001

W/O: 4114 TSS P/N: 8927 Qty.: 1 Customer P/N: <u>D3218-041</u> Dwg. No.: <u>D3218</u> Rev.: <u>A</u> Date:

Cuttin	g IAW PCS 003	Marking	IAW PCS 004	Bonding	IAW PCS 002	J. Si	lkscreen'
Operator No.	Date	Operator No.	Date	Operator No.	Date	Operator No.	Date
ļ	1.1.			<u> </u>	<u>ented below)</u>		
<u> </u>					<u> </u>		

<sup>\*</sup> Note: PCS 006, there shall be a total of 2 samples submitted for the Testing of the Adhesive (Peel and Shear Test), at start and end of every production day, record on sheet 3/3

Stages & Descriptions	Operator	Operation	Accept.	Reject.	NCR	Total	Insp.	Date
	No. + Date	e peration	Qty.	Qty.	TVUI	Accept.	Stemn	Date
1- a) a) Attach Panel A (uneven edge) to larger edge of Panel B, centered on a 2" inner tape (butt joint)± 1/8"	156 10 feb 05	ગાલ્ય 28	j			1		Jeb10/05
b) Attach (6) Valve Flanges on Panel A: 2-Relief, 2-Inlet & 2- Topping Up	156 100 CG	7104-28 Bate 1104-28	G	<u></u>	-	6	(11)	Feek 8/0 5
c) Attach (6) Doublers on above Flanges	8 Jul 2	Bonding	le	•		6	KATY	Jep 2/05
2- a) Attach Panel C to Straight edge of Panel A, centered on a 2" inner Tape (butt joint) ± 1/8"	156 1560.05	9104-28	į			1		Feb. 10/05
3- a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape	10 fe U 05	Al04-28	/	-		1	(100)	teb11/05
4- a) Baffle Ass'y. with 2" Tape ± 1/8"	10 FEU. 05	<b>.</b>	1		-	1	(33)	Lob10/05
5- a) Attach Baffle Ass'y. to Bag (in 3 stages, minimum)	110 14 Feu 05	Bonding	1			1	(13)	Ab14/05
6- a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time	12 21 Marsos	Testing (see sheet-2)	,	•	-	1	X3 3X	Mars 21/05
7- a) Closure of 1" Main Seam (overlap) ± 1/8"	7100 65	Bonding	/	<b>-</b>	_	/	1 4 1	april 28/05
b) Attach ID Patch (ref. CAR 04-003)	# // 3Hai 05		/_		-	/	A	May 4/05
8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time	12 26/april /05	Testing (see sheet 2)	,			ı	( A)	as illastic
9- a) Attach 1" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8"			/			/		May 4/05
b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bag		_ Bonding _	1	_	~	/ (		May 4/05
c) Attach 5" split patch on each end (x 4)	2/05/20	_ 29	/		~	/		May 4/05

Rev. D Sheet 2/3

Stages & Descriptions	Operator No. + Date Operation	Accept. Reject. Qty. Qty.	NCR Total	Insp. Datë
10- a) Final Test			334	
b) Inspector to Stamp on ID Patch:	Testing .			
Serial No.: B	(see sheet 3)			
& Inspection Stamp beside the S/N				
Upon completion of the (final) leakage test, the ID Patch shall be stamped with 5/16 " hig	h lettering and black ink: serial number (7 d	igits), provided by DART (ref	er to W/O) * Verify the inte	parity of the Valves (Throads/gaskots)

Test Conditions – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

#### Baffle Test!

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams. Inflation Test: Lower Chamber to 3.00 psi, re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase

- # 0.054 PSI for each 1°C of temperature decrease
- + 0.049 PSI for each 0.1 inch of barometric increase ... 0.049 PSI for each 0.1 inch of barometric decrease

Chambers	Pressure	5 Min. Over P. & Soap Test	Sta	45 Minute bilizing Per						1 Ho	our Test		hume	13 %
		Pass / Fail	Design Pressure	Time On	Time Off	Design Pressure	Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail
# 1 (see note 1)	4.36 PSI	Pass	3.00 PSI	2:30	3:15	3.00 PSI	3:15	4:15	3. 00 PSI	24 24	29. 78 29. 78		3UU PSI	Pusa
Re-Test													humi	27%
# 2 (Main Seam)	4.36 PSI	Pass	3.00 PSI	9:20	10:00	3.00 PSI	10:00	11:00	3. <b>∪5</b> PSI	22 23	29.62 29.62	-0.054	2.99 t	Pass
Re-Test		,												

Note 1: Chamber # 1 requires Dart Aerospace Approval Signature:	Chr. Prove	in	Date:	04.04.18	,
Observations: OK	· · · · · · · · · · · · · · · · · · ·				

Rev. D Sheet 3/3

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening closing time and pressure. The opening pressure shall be between 3.3 – 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girl assembly.

Pressure Relief		Оре	ening	Cl	osing	
Valve Test	PRV Serial Numbers	Time ON	Pressure	Time	Close	Pass / Fail
Chamber # 1	337/8	9:45	3.50 PSI	9:50	3,25 PSI	Pusa
Chamber # 2 (Main Seam)	33721	10:45	3.38 PSI	10150	3.14 PSI	Pass

Chambers	Design		24 Hour Leakage Test								
	(closing) Pressure as per above	Time On	Time Off	Read'g	Temp. Start/End	· 1		Final Read'g	Pass / Fail		
#1	3,25 PS	9:50	9:50	2,60 PSI	24' 21"	30.07 30.34	+ 0.162	2.89 PSI	Pass		
Re-Test							7 0.700		icae		
# 2 (Main Seam)	3.14 PS	10:50	10:50	2.47 PSI	aa' aa'	30.34 30,15	-0.054	2.38 PSI	Pass		
Re-Test									- (		

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	± 0.100 *	3,5	Paso	47.0	± 0.5	46 7/8	( Pasy	24.75	± 0.5	25 1/9	10
7.3	± 0.100 *	7. 3	Pass	* = 1/	AW QSI 018, re	v. A dated 03-05-29	(A)	31.0	± 0.5	31.1/4	Pass

#### Submission of Adhesive Testing

		Subm.Date / am-pm	Pass/Fail	Subm.Date / ampm	Pass/Fail	Subm.Date / am-pm	Pass/Fail	Subm.Date / am-pm	Pass/Fail
-e	24 hour	Jeb 10/05	Pass	may 2/05	Paas		· · · · · · · · · · · · · · · · · · ·		
4	7 day	Feb 10/05	Pass	may 2/05	Puss				
r s	24 hour	9eb 10/05	Pass	may 2/05	pass	,			
She	7 day	Jeb 10/05	Pass	May 2/05	Pass	·			

**TULMAR** 

### **Product Inspection Form # 193–8927(Tube & Final)**

Rev. D Sheet 1/3

**Description**: Float Bag Assembly  $\leq 10!$  B 2 18 29 - 16

-Items are Manufactured IAW Process Control Specification No. 001, 002, 003, 004, 005, 006, and are to be 100% inspected I.A.W. P.I.P. 001 5/01 W/O: 20153 Customer P/N: <u>D3218-041</u> TSS P/N: 8927 Qty.: 1 Dwg. No.: <u>D3218</u> Rev.: A Date: SIF order: 4114 CSM Cutting IAW PCS 003 Bonding IAW PCS 002 Marking IAW PCS 004 Silkscreen Operator No. Date Operator No. Date Operator No. Date Operator No. Date (Documented below)

\* Note: PCS 006, there shall be a total of 2 samples submitted for the Testing of the Adhesive (Peel and Shear Test), at start and end of every production day, record on sheet 3/3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept	Insp.—Stamp	Date
<ul> <li>1- a) a) Attach Panel A (uneven edge) to larger edge of Panel B, centered on a 2" inner tape (butt joint)± 1/8"</li> <li>b) Attach (6) Valve Flanges on Panel A: 2-Relief, 2-Inlet &amp; 2- Topping Up</li> <li>c) Attach (6) Doublers on above Flanges</li> </ul>		Bonding						
2- a) Attach Panel C to Straight edge of Panel A, centered on a 2" inner Tape (butt joint) ± 1/8"								
3- a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape								
4- a) Baffle Ass'y. with 2" Tape ± 1/8"								
5- a) Attach Baffle Ass'y. to Bag (in 3 stages, minimum)		Bonding	,				,	
6- a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time		Testing (see sheet 2)						
7- a) Closure of 1" Main Seam (overlap) ± 1/8" b) Attach ID Patch (ref. CAR 04-003)		Bonding						
8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time		Testing (see sheet 2)						
9- a) Attach 1" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8"		Bonding					·	
(b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bag c) Attach 5" split patch on each end (x 4)		Donaing						

Rev. D Sheet 2/3

Stages & Descriptions	Operator No. + Date	Operation Accept.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date
10- a) Final Test				32 3 3 3 3 3		38-35, 110,000 mm Tour 1	3480
b) Inspector to Stamp on ID Patch:						488	
Serial No.: B 2 1 8 2 9 - 16	12	Testing (see sheet 3)	,		)	( A	ang 16/07
& Inspection Stamp beside the S/N	10	(See sheer 5)	•				
Upon completion of the (final) leakage test, the ID Patch shall be stamped with 5/16 " high	lettering and black	ink: serial number (7 digits), provided b	v DADT (refer	to W/O) * 1	Varify the inter-	-i4 6 Ab - 37.1	(T) 1/ 1/ 1

Test Conditions – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

#### Baffle Test:

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams. Inflation Test: Lower Chamber to 3 00 psi, re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase

+ 0.054 PSI for each 1°C of temperature decrease

+ 0.049 PSI for each 0.1 inch of barometric increase

- 0.049 PSI for each 0.1 inch of barometric decrease

Chambers	Pressure	5 Min. Over P. & Soap Test	l .	45 Minute bilizing Per							1 Ho	our Test				
		Pass / Fail	Design Pressure (עשייט/ט)	Time On	Time Off	Design Pressure	Time On	Time Off	Read'g	i i	mp. t/End	1	rom. t/End	Adjust.	Final Read'g	Pass / Fail
# 1 (see note 1) Re-Test	4.36 PSI		3.00 PSI		11:35	3.00 PSI	11:35	12:35	3,00 PSI	25	25	29.77	29.77		3.00 PSI	Puss
# 2 (Main Seam) Re-Test	4.36 RSI	<i>,</i>	3.00 PSI		91.15	3.00 PSI	9:20	10:20	3.00 PSI	23	<i>\$</i> 3	29.75	. <i>)9.7</i> 5		3.00 PSI	Ecos

Note 1: Chamber # 1 requires Dart Aerospace Approval Signature:	NIA	Date: $N/a$
Observations: •	/	
	The second secon	

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### S/N. B21829-16

### **Product Inspection Form # 193-8927(Tube & Final)**

Rev. D Sheet 3/3

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open: Record the opening/closing time and pressure. The opening pressure shall be between 3.3 – 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girl assembly:

Pressure Relief		Op	ening	Cl	losing Municy	
Valve Test	PRV Serial Numbers	Time ON	Pressure	Time	Close	Pass / Fail
Chamber # 1	33724	11:05	3.26 PSI	11:10	3.06 PSI	Pass
Chamber # 2 (Main Seam)	32715	12:10	3.42 PSI	12:15	3.00 PSI .	Pass

Chambers	Design				24 Hour L	eakage Test			
aug 13/07	(closing) Pressure as per above	Time On	Time On Time Off		Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail
#1	3,06 PSI	11!10	11:10	2.44 PSI	24 23	29.74 29.86	0,054	2.59 PSI	Cos
Re-Test									
(Main Seam)	3.00 PSI	12:15	12:15	226 PSI	23 23	29.84 29.63	0.113	2.15 PSI	Pass
Re-Test						:			10000

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	± 0.100 *			47.0	± 0.5	. \	,	24.75	± 0.5		
7.3	± 0.100 *			* = IA	W QSI 018, re	v. A dated 03-05-29	Na	31.0	± 0.5		

#### Submission of Adhesive Testing

		Subm.Date / am-pm	Pass/Fail						
<u></u>	24 hour								
A A	7 day				Nla				
ž.	24 hour								
She	7 day							-	·

**ILMAR** 

### **Product Inspection Form # 193–8927(Tube & Final)**

**Description**: Float Bag Assembly

-Items are Manufactured IAW Process Control Specification No. 001, 002, 003, 004, 005, 006, and are to be 100% inspected I.A.W. P.I.P. 001

Customer P/N: D3218-041

Dwg. No.: D3218 Rev.: A Date: Feb / 05

Rev. D. Sheet 1/3

Cutti	ng IAW PCS 003	Markir	ig IAW PCS 004	Bonding	IAW PCS 002		Silkscreen
Operator No.	Date	Operator No.	Date	Operator No.	Date	Operator No.	Date
		-		( Dogume	ented below		
				( Docume	ented below)	<del>- </del>	

<sup>\*</sup> Note: PCS 006, there shall be a total of 2 samples submitted for the Testing of the Adhesive (Peel and Shear Test), at start and end of every production day, record on sheet 3/3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR.	Total Accept.	Insp.:	" Date
1- a) a) Attach Panel A (uneven edge) to larger edge of Panel B, centered on a 2" inner tape (butt joint)± 1/8"	154 114EV-05	'11¢1' Z8	/			1	(11)	Feb 11/05
b) Attach (6) Valve Flanges on Panel A: 2-Relief, 2-Inlet & 2- Topping Up c) Attach (6) Doublers on above Flanges	117 mieros	Bate W 28	6	-		6	15	Feb 9/05
2- a) Attach Panel C to Straight edge of Panel A, centered on a 2" inner Tape (butt joint) ± 1/8"	1540 11-164-05	Bonding 기업-28	1			1	(38)	teb 4/05
3- a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape	560 1018465	'4104-28 s s	1			1		teb14/05
4- a) Baffle Ass'y. with 2" Tape ± 1/8"	110 11 Fev. 05	B 2 1:22	1	,	14000	1		teb 11/05
5- a) Attach Baffle Ass'y. to Bag ( in 3 stages, minimum )	17 Fev.05	Bonding	ノ		_	1		Feb 17/05
6- a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time	12 21 mars u S	Testing (see sheet 2)	1			(		Mars 21/05
7- a) Closure of 1" Main Seam (overlap) ± 1/8"	21/0/1/05	7109 Bonding	/	•		/	<b>6</b>	may 3/05
b) Attach ID Patch (ref. CAR 04-003)	110 615/65 12	9ي	/				384	may 2/05
8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time	May 3/05	Testing (see sheet 2)	. /			1	(4)	Mary 3/05
9- a) Attach 1" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8"	5/5/05	7164	,	-		1	1.8.8	
b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bag c) Attach 5" split patch on each end ( x 4 )	5/05/05 5/05/05	Bonding ・29	l	-	_	/	9	9/05

Rev. D Sheet 2/3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date
10- a) Final Test								
b) Inspector to Stamp on ID Patch:		Testing						
Serial No.: <b>B</b>		(see sheet 3)						
& Inspection Stamp beside the S/N								
Upon completion of the (final) leakage test, the ID Patch shall be stamped with 5/16 " hig	h lettering and black	ink: serial number (7 digit	ts) provided l	hy DART (refer	r to W/O)	Verify the into	arity of the V	alves (Threads/gaskets)

**Test Conditions** – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

#### Bäffle Test:

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source: Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams. Inflation Test: Lower Chamber to 3.00 psi; re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase

- + 0.054 PSI for each 1°C of temperature decrease
- + 0.049 PSI for each 0:1 inch of barometric increase 0.049 PSI for each 0.1 inch of barometric decrease

Chambers	Pressure	5 Min. Over P. & Soap Test		45 Minute bilizing Per						1 Ho	ur Test	hum 12 %			
Chambers	,	Pass / Fail	Design Pressure	Time On	Time Off	Design Pressure	Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail	
# 1 (see note 1)	4.36 PSI	Pass	3.00 PSI	1:15	À:15	3.00 PSI	2:15	3:1 <b>5</b>	3.00 PSI	24 24	29.79 29.79		3 00 PSI	Pass	
Re-Test															
# 2 (Main Seam)	4.36 PSI	Pass	3.00 PSI	9:50	10:35	3.00 PSI	10:35	13,35	3.00 PSI	23° 23	29.77 29.78	0.004	00 <u>کی</u> PSI	Pass	
Re-Test		;													

Note 1: Chamber # 1 requires Dart Aerospace Approval Signature: _	Chan Proverer	Date:	05.A.18
Observations:	,		

Rev. D Sheet 3/3

Pinal Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 18L soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 - 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

\*Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the types and girt assembly.

Pressure Relief		Ор	ening	Cl		
Valve Test	PRV Serial Numbers	Time ON	Pressure	Time	Close	Pass / Fail
Chamber # 1	33724	2:55	3,29 PSI	3100	3,02 PSI	Pass
(hamber # 2 (Main Seam)	. 33715	4105	3.47 PSI	4:10	3,06 PSI	Riss

	hambers	Design				24 Hour L	eakage Test			
		(closing) Pressure as per above	Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail
	# 1 Re-Test	3,02 PSI	3:00	3:00	2.61 PSI	25 25	29.83 29.64	-0.093	2.51 PSI	Passi
<b>-</b>	# 2 ain Seam) Re-Test	3,06 PSI	4:10	4:10	2.27 PSI	25 25	29.64 29.65	70.004	2.28 PSI	Pass

I)im.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	± 0.100 *	3.5	Pass	47.0	± 0.5	46 318	ton	24.75	± 0.5	35118	Pass
7 3	± 0.100 *	7.3	Pass	* = I	AW QSI 018, re	v. A dated 03-05-29	14.2	31.0	± 0.5	31.5	Para
					<b>(</b> ,,		\ <b>A</b> . /				

#### Submission of Adhesive Testing:

L_		Subm.Date / amppm	Pass/Fail	Subm.Date / am-pm	Pass/Fail	Subm.Date / sim (pi)	) Pass/Fail	Subm.Date / am-pm	Pass/Fail
ee	24 hour	Feb 11/05	Pass	Feb 17/05	Pass	may 5/05	Pasa		<del>- 1 11.</del>
	7 day	Feb 11 105	Pass	Feb 17/05	Para	may 5/05	Pass		
ear	24 hour	Jen 11/05	Pas	Jeb 17/05	Pass	may 5/05	Pass	·	
T &	7 day	Feb 11/05	Pass	Feb 17/05		They 5/65	Puss		

Rev.	D	Sheet	1/3

**Description**: Float Bag Assembly

S/N: B2/829-17

-Items are Manufactured IAW Process Control Specification No. 001, 002, 003, 004, 005, 006, and are to be 100% inspected I.A.W. P.I.P. 001

S/0: XXXIO: 20153 TSS P/N: 8927 Customer P/N: D3218-041 Dwg. No.:D3218 **Qty.:** 1 Rev.: A Date: Cutting IAW PCS 003 Marking IAW PCS 004 Silkscreen Bonding IAW PCS 002 Operator No. Date Operator No. Date Operator No. Date Operator No. Date Documented below

<sup>\*</sup> Note: PCS 006, there shall be a total of 2 samples submitted for the Testing of the Adhesive (Peel and Shear Test), at start and end of every production day, record on sheet 3/3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date
<ul> <li>a) a) Attach Panel A (uneven edge) to larger edge of Panel B, centered on a 2" inner tape (butt joint)± 1/8"</li> <li>b) Attach (6) Valve Flanges on Panel A: 2-Relief, 2-Inlet &amp; 2- Topping Up</li> <li>c) Attach (6) Doublers on above Flanges</li> </ul>		Bonding						
2- a) Attach Panel C to Straight edge of Panel A, centered on a 2" inner Tape (butt joint) ± 1/8"								
3- a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape								
4- a) Baffle Ass'y. with 2" Tape ± 1/8"		Bonding						·
5- a) Attach Baffle Ass'y. to Bag ( in 3 stages, minimum )		Bulling	,				,	
6- a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time		Testing (see sheet 2)						
7- a) Closure of 1" Main Seam (overlap) ± 1/8" b) Attach ID Patch (ref. CAR 04-003)		Bonding						
8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time		Testing (see sheet 2)				·	-	
9- a) Attach 1" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8"		Balla						
b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bag c) Attach 5" split patch on each end ( x 4 )		Bonding						

Rev. D Sheet 2/3

Stages & Descriptions	Operator No. + Date		Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date.
10- a) Final Test								<u> </u>
b) Inspector to Stamp on ID Patch:		Testing					4.8	0 - 4 3007
Serial No.: B 2 / 8 2 9 - / 7	12	(see sheet 3)	1	i Primary.		1		aug 16 200)
& Inspection Stamp beside the S/N							, appropries	
Upon completion of the (final) leakage test, the ID Patch shall be stamped with 5/16 " high	lettering and black	ink: serial number (7 digi	ts), provided b	y DART (refer	to W/O). *	Verify the integ	rity of the Valv	es (Threads/gaskets).

**Test Conditions** – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

#### Baffle Test:

Over Pressure: Using socket tool and torque wrench s/n 0801300327; tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams. Inflation Test: Lower Chamber to 3.00 psi, re-adjust after 45 minutes. After 1 hours take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase + 0.054 PSI for each 1°C of temperature decrease

- + 0.049 PSI for each 0.1 inch of barometric increase
- 0.049 PSI for each 0.1 inch of barometric decrease

Chambers	Pressure	5 Min. Over P. & Soap Test	45 Minute Stabilizing Period			1 Hour Test								
		Pass / Fail	Design Pressure	Time On	Time Off	Design Pressure	Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail
# 1 (see note 1)	4.36 PSI		3.00 PSI	10:50	11:35	3.00 PSI	11:35	12:35	3.00 PSI	25 25	29.77.29.77	-	3.00 PSI	Pass
Re-Test			رة إماويين											
# 2 (Main Seam)	4.36 PSI		3.00 PSI	8:30	9:15	3.00 PSI	9:20	10:20	3.00 PSI	a3 23	29.75 29.75		ろ.w PSI	Cess
Re-Test														

Note 1: Chamber # 1 requires Dart Aerospace Approval	Signature:	wile	Date:	Na.	
Observations:	·			/	

5/0:20153

# TULMAR #5

### S/N: B21829-17

### Product Inspection Form # 193-8927(Tube & Final)

Rev. D Sheet 3/3

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 – 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below: Perform additional inspection of the tapes and girt assembly.

Pressure Relief		Оре	ening	Clo	Closing		
Valve Test	PRV Serial Numbers	Time ON	ime ON Pressure			Pass / Fail	
Chamber # 1	33720	11:10	3. 22 P	SI //:/5	3.06 PS		
Chamber # 2 (Main Seam)	33728	12:10	3 28 P	SI /2:15	3.08 PS	SI	

	Design					24	Hour Le	eakage Test	-			
Crug /3/07	(closing) Pre as per abo	H	Time On	Time Off	Read'g	Ten Start/		Bar Start		Adjust.	Final Read'g	Pass / Fail
#1	306	PSI	//:15	11:15	2.60 PSI	24	23	29.74	29.86	to.054	2.71 PSI	Coss
Re-Test												
(Main Seam)	3.08	PSI	12:15	12:15	2.38 PSI	23	23	29.84.	29.63	0.112	2.27 PSI	Cass
Re-Test												

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actua Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	± 0.100 *			47.0	± 0.5	. \		24.75	± 0.5		
7.3	± 0.100 *			* = IAW QSI 018, rev. A dated 03-05-29 W				31.0	± 0.5		

	<u> </u>	Subm.Date / am-pm	Pass/Fail						
ē	24 hour								
a a	7 day				Nk				
ѫ	24 hour				1.1		····		
She	7 day								

Rev. D Sheet 1/3

**Description**: Float Bag Assembly

-Items are Manufactured IAW Process Control Specification No. 001, 002, 003, 004, 005, 006, and are to be 100% inspected I.A.W. P.I.P. 001

TSS P/N: 8927

Customer P/N: <u>D3218-041</u>

Dwg. No.: D3218 Rev.: A Date: Fels / v 5

Cutting L	W PCS 003	Marking I	AW PCS 004	Bonding I	AW PCS 002	Sil	kscreen
Operator No.	Date	Operator No.	Date	Operator No.	Date	Operator No.	Date
	· · · · · · · · · · · · · · · · · · ·			(Docume)	nted below)		

<sup>\*</sup> Note: PCS 006, there shall be a total of 2 samples submitted for the Testing of the Adhesive (Peel and Shear Test), at start and end of every production day, record on sheet 3/3

Stages & Descriptions	Operator No. + Date	Operation	Accept.  Qty:	Reject. Qty.	NCR.	Total Accept.	∃Insp. ≰Slamp	Date
1- a) a) Attach Panel A (uneven edge) to larger edge of Panel B, centered on a 2" inner tape (butt joint)± 1/8"	156 14/20.05	7104:28	1	_		1	9	Feb. 14/05
b) Attach (6) Valve Flanges on Panel A: 2-Relief, 2-Inlet & 2- Topping Up c) Attach (6) Doublers on above Flanges	119 www 05	Batalion-C	6	_		6	The same	Feeb 9/05
2- a) Attach Panel C to Straight edge of Panel A, centered on a 2" inner Tape (butt joint) ± 1/8"	156 14 JEU 05	Bonding 가(ツ・28	4	# ·	g sterme	1	3	F2614/03
3- a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape	156 14 JEV. 05	7104-28	1	-		1	(3)	Jeh 14/05
4- a) Baffle Ass'y. with 2" Tape ± 1/8"	4110	J104-58	1			/		Jeb 14/05
5- a) Attach Baffle Ass'y. to Bag (in 3 stages, minimum)	# MC 14 Leo OS	Bonding	. /		)	/	(11)	Feb 17/05
6- a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time	120 21 mars 05	Testing (see sheet 2)	,	***		1	(35) (4)	Mars 21/05
7- a) Closure of 1" Main Seam (overlap) ± 1/8"	21/04/05	7104 Bonding	1			/	97.	may 3/05
b) Attach ID Patch (ref. CAR 04-003)	6/5/05	- 1976	1		_	/		may 9/05
8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time	12 May 3 /2005	Testing (see sheet 2)	/	_	1	1	(4)	May 3/05
9- a) Attach 1" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8"	4May 05	7/04-	1			(	(1.00)	
b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bag	#15/5/05	Bonding	(			1	(9)	)May 9/05
c) Attach 5" split patch on each end (x 4)	5/05/00	, 29	1		_	1		

Rev. D. Sheet 2/3

Stages & Descriptions	Operator No. + Date Operation	Accept. Reject. Qty.	NCR.	Total Accept.	Insp. Stamp	Date :
10- a) Final Test b) Inspector to Stamp on ID Patch:	Testing					
Serial No.: <b>B</b>	(see sheet 3)					
& Inspection Stamp beside the S/N		3				
Upon completion of the (final) leakage test, the ID Patch shall be stamped with 5/16 " hig	th lettering and black ink: serial number (7	digits), provided by DART (t	efer to W/O).	* Verify the into	egrity of the V	alves (Threads/gaskets).

**Test Conditions** – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

#### Baffle Test:

Over Pressure: Using socket tool and torque wrench s/n 0801300327; tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief Valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams. Inflation Test: Lower Chamber to 3.00 psi; re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase -
- + 0.054 PSI for each 1°C of temperature decrease
- + 0.049 PSI for each 0.1 inch of barometric increase
- 0.049 PSI for each 0.1 inch of barometric decrease

Chambers	Pressure	5 Min. Over P.	1	45 Minute bilizing Per		1 Hour Test humg 15/							<b>ມ</b> "/ວ .	
Chambers		Pass / Fail	Design Pressure	Time On	Time Off	Design Pressure	Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail
# 1 (see note 1)	4.36 PSI	Pass	3.00 PSI	1:50	2:35	3.00 PSI	2135	3.35	3.00 PSI	24 24	29.18 29.78	-/	3. 00 PSI	Piss.
Re-Test		<b>,</b>										i.		
# 2 (Main Seam)	4.36 PSI	Passi	3.00 PSI	11:00	11:45	3.00 PSI	11:45	12:45	3.00 PSI	23' 23	29.78 29.78		3. 00 PSI	Pass
Re-Test		\ -												

Note 1: Chamber	# 1 requires Dart	Aerospace Approval Signature:	Chan theren	/Date:_	65.64.18
Observations:	OK				

1

Rev. D Sheet 3/3

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing: A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 = 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2):

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief		Op	ening	Clo	D / F 1	
Valve Test	PRV Serial Numbers	Time ON	Pressure	Time	Close	Pass / Fail
Chamber # 1	33720	2:50	3,35 PSI	Q. 55	3,06 PSI	Pass
Chamber # 2 (Main Seam)	33728	4:20	3,25 PSI	4:25	3.08 PSI	Pass

Chambers	Design		24 Hour Leakage Test										
Cijalilbeis	(closing) Pressure as per above	Time On Time Off		Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail				
# 1 Re-Test	3.06 PSI	a:55	2:55	2.66 PSI	<i>35</i> 25	01.89 29.64	-0.093	2.56 PSI	Pass				
# 2 (Main Seam)	3.08 PSI	4:25	4:05	2.36 PSI	25° 25°	29.64 29.65	70,004	2.37 PSI	Pass				
Re-Test							7 0,00	V.3.					

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	± 0.100 *	3,5	lass	47.0	± 0.5	47.	1 House	24.75	± 0.5	25 1/4	Pasa
7.3	± 0.100 *	7.3	Pass	* = IAW	QSI 018, re	v. A dated 03-05-29	4	31.0	± 0.5	31.5	Pass

		Subm.Date /ampm	Pass/Fail	Subm.Date / ameppa	Pass/Fail	Subm.Date /and-pm	Pass/Fail	Subm.Date / am-pm	Pass/Fail
- e	24 hour	Jeh 15/05	Pass	may 4/05	Pass	may 6/05	Puss	÷	
Ā	7 day	Feb 15/05	Pass	may 4/05	Pass	may & 105	Pass		
ar	24 hour	Feb 15/05	Pass	may 4/05	Pass	may 6/05	Pass		
She	7 day	Feb 15/05	Puss	may 4/05	Pass	may 6/05	Passi		

**TULMAR** 

# Product Inspection Form # 193-8927(Tube & Final)

Description: Float Bag Assembly 8/N; B21829-18

Rev. D Sheet 1/3

10: 2015.  Foder:	3 TSS P/N: 8	8927 Qty.: <u>1</u>	Customer P/N:	<u>D3218-041</u> Dwg	g. No.: <u>D3218</u> R	lev.: A Date:	
Cutting	IAW PCS 003	Marking	IAW PCS 004	Ronding 1	IAW PCS 002	CSM.	· III-aasiaasi
Operator No.	Date	Operator No.	Date	Operator No.	Date	Operator No.	ilkscreen Date
				(Docume	nted below)		

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject.	-NCR	Total Accept.	Insp. Stamp	Date
<ul> <li>a) a) Attach Panel A (uneven edge) to larger edge of Panel B, centered on a 2" inner tape (butt joint)± 1/8"</li> <li>b) Attach (6) Valve Flanges on Panel A: 2-Relief, 2-Inlet &amp; 2- Topping Up</li> <li>c) Attach (6) Doublers on above Flanges</li> </ul>								
2- a) Attach Panel C to Straight edge of Panel A, centered on a 2" inner Tape (butt joint) ± 1/8"		Bonding						
3- a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape								
4- a) Baffle Ass'y. with 2" Tape ± 1/8"								
5- a) Attach Baffle Ass'y. to Bag (in 3 stages, minimum)		Bonding	,				_	
6- a) Perform Baffle Test on Chamber # Lafter a 3 day Cure Time		Testing (see sheet 2)						
7- a) Closure of 1" Main Seam (overlap) ± 1/8" b) Attach ID Patch (ref. CAR 04-003)		Bonding						
8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time		Testing						
9- a) Attach 1" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8"								
b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bag		Bonding						
c) Attach 5" split patch on each end (x 4)								

Rev. D Sheet 2/3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date
10- a) Final Test							480	
b) Inspector to Stamp on ID Patch:		Testing					, , , ,	aug 162007
Serial No.: B <u>2 1 8 2 9 - 1 8</u>	12	(see sheet 3)	1	1900	None.	1 .	1	and the
& Inspection Stamp beside the S/N	·							

**Test Conditions** – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

Upon completion of the (final) leakage test, the 1D Patch shall be stamped with 5/16 " high lettering and black ink; serial number (7 digits), provided by DART (refer to W/O). \* Verify the integrity of the Valves (Threads/gaskets).

#### Baffle Test:

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage: Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams.

Inflation Test: Lower Chamber to 3.00 psi, re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase
- + 0.054 PSI for each 1°C of temperature decrease
- + 0.049 PSI for each 0.1 inch of barometric increase
- 0.049 PSI for each 0.1 inch of barometric decrease

Chambers	Pressure	5 Min. Over P. & Soap Test	Sta	45 Minute bilizing Per	1	1 Hour Test								
		Pass / Fail	Design Pressure Jung 10/67	Time On	Time Off	Design Pressure	Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail
# 1 (see note 1)	4.36 PSI		3.00 PSI	1050	11:35	3.00 PSI	11:35	12:35	3.00 PSI	25 25	29.77 29.77		300 PSI	Pass
Re-Test			aug 13/0	<u> </u>										
# 2 (Main Seam)	4.36 PSI		3.00 PSI	8:25	9:10	3.00 PSI	920	10'.20	3.00 PSI	23 23	29.75 29.15		3 0 0 PSI	Pass
Re-Test														

Note 1: Chamber # 1 requires Dart Aerospace Approval Signature:	N/cu	Date:	
Observations:	<i>'</i>	, , , , , , , , , , , , , , , , , , ,	

CULMARaigned # 6\_

### SIN: BQ1829-18 Product Inspection Form # 193-8927(Tube & Final)

Rev. D Sheet 3/3

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 l'SI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 – 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

I pon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief		Ор	ening	Clo	3 hung %	
Valve Test PRV Serial Numbers		Time ON	Pressure	Time	Close	Pass / Fail
Chamber # 1	33727	11:15	3.47 PSI	11:20	3.26 PSI	Pass
Chamber # 2 (Main Seam)	33725	12:10	3.48 PSI	12:15	3.31 PSI	Pass

Chambers	Design		24 Hour Leakage Test										
ang/3/07	(closing) Pressure as per above	Time On	Time Off Read'g		Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail				
# I	3.26 PSI	11:30	11:20	2.75 PSI	24 23	29.74 29.86	+0.054	2.86 PSI	Passi				
(Main Seam) Re-Test	3,31 PSI	19.15	12.15	2.47 PSI	23 23	29.86 29.63	0.112	2.36 PSI	Pass				

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual	Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	± 0.100 *			47.0	± 0.5				24.75	± 0.5	- 18	
7.3	± 0.100 *			* = IAV	V QSI 018, re	v. A dated 0	3-05-29	. /	31.0	± 0.5		
					. 292 010,10	T. IX GUICG O.	J 0J <b>L</b> )	nHa				

		Subm.Date / am-pm	Pass/Fail						
<b>-</b>	24 hour			·					
a	7 day		•		. 1				
ar	24 hour				Na				
She	7 day		:						

# ULMAR

# Product Inspection Form # 193-8927(Tube & Final)

Rev. D Sheet 1/3

**Description**: Float Bag Assembly

-Items are Manufactured IAW Process Control Specification No. 001, 002, 003, 004, 005, 006, and are to be 100% inspected I.A.W. P.I.P. 001

TSS P/N: 8927

Customer P/N: <u>D3218-041</u>

Dwg. No.: D3218 Rev.: A Date: Fels/05

Cutti	ng IAW PCS 003	Markin	g IAW PCS 004	Bonding	IAW PCS 002		Silkscreen
Operator No.	Date	Operator No.	Date	Operator No.	Date	Operator No.	Date
				( Docume	<u>nted below )                                    </u>		,
				1			

<sup>\*</sup> Note: PCS 006, there shall be a total of 2 samples submitted for the Testing of the Adhesive (Peel and Shear Test), at start and end of every production day, record on sheet 3/3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty,	Reject. Qty.	NCŔ	Total Accept.	Insp. Stornp	Date
1- a) a) Attach Panel A (uneven edge) to larger edge of Panel B, centered on a 2" inner tape (butt joint)± 1/8"	150 HJEV 05	Bath 7104-28	1			/	45	Feb 14/05
b) Attach (6) Valve Flanges on Panel A: 2-Relief, 2-Inlet & 2- Topping Up	11 nuros	Bale 1104-28	6			6	(11)	Feb 9/05
c) Attach (6) Doublers on above Flanges	8 FIL	Bonding	6			6	(420)	£69/05
2- a) Attach Panel C to Straight edge of Panel A, centered on a 2" inner Tape (butt joint) ± 1/8"	156 MJE11.05	7109-24						teb 14/05
3- a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape	15/EV 05	3104-28	/			1	Gi	Feb 14/05
4- a) Baffle Ass'y. with 2" Tape ± 1/8"	19 Fev. 05	Bonding	1	Mitheusenger o	_	/	133	Feb14/05
5- a) Attach Baffle Ass'y. to Bag (in 3 stages, minimum)	1860 05		1			/ (	it.	Feb18/05
6- a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time	12 24 Mars 05	Testing (see sheet 2)	1	·		١		mais 24/05
7- a) Closure of 1" Main Seam (overlap) ± 1/8"	21/04/05	りゃり Bonding	1	-	~	1	Colonia Coloni	april 28/05
b) Attach ID Patch (ref. CAR 04-003)	6/05/05	29	1			/		May 9/05
8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time	May 4 3005	Testing (see sheet 2)	Į			1		May 4/05
9- a) Attach 1" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8"	#110 5/5/05	7/04	1	***************************************	_	(	1.68	
b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bag	5/5/05	Bonding	1	_	_	1	(9	May 9/us
c) Attach 5" split patch on each end ( x 4 )	5/5/05	29	1					

TULMAR #4

### Product Inspection Form # 193-8927(Tube & Final)

Rev. D Sheet 2/3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date
10- a) Final Test b) Inspector to Stamp on ID Patch:		Testing						
Serial No.: B		(see sheet 3)						
Unon completion of the (final) leakage test the ID Databakell he stammed with EIIC " his	L	Kinga 828	1	ha DADT (asfer	- 4- M/O)			alves (Threads/gaskets)

**Test Conditions** – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

#### Baffle Test:

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams.

Inflation Test: Lower Chamber to 3.00 psi; re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase
- + 0.054 PSI for each 1°C of temperature decrease
- + 0.049 PSI for each 0.1 inch of barometric increase
- 0.049 PSI for each 0.1 inch of barometric decrease

Chambers	Pressure	5 Min. Over P. & Soap Test		45 Minute bilizing Per							1 Ho	ur Test	h	umy lä	1 %
Chambers	riessure	Pass / Fail	Design Pressure	Time On	Time Off	Design Pressure	Time On	Time Off	Read'g	Tei Start	•	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail
# 1 (see note 1)	4.36 PSI	Pass	3.00 PSI	8:15	9:00	3.00 PSI	9:00	10:00	3.00 PSI	<b>ત્રે</b> ર)	22	29.81 39.81	7_	3 00 PSI	Pass
Re-Test											! ! !				
# 2 (Main Seam)	4.36 PSI	Pass	3.00 PSI	8:50	9:30	3.00 PSI	9:35	10:35	3.00 PSI	24"	24	30.07 30.10	0.014	3.01 PSI	Pass
Re-Test											* * * * * * * * * * * * * * * * * * *				

Note 1: Chamber # 1 requires Dart Aerospace Approval Signature:	Chan Prome	/ Dat	te: 05.04,18
Observations: OK			

Rev. D Sheet 3/3

Final Test: Leakage / Relief Valves. The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00. PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3—3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx: 2.00 PSI and perform Dimensional Verification below... Perform additional inspection of the tapes and girt assembly.

Pressure Relief		Ope	ening	Clo		
Valve Test	PRV Serial Numbers	Time ON	Pressure	Time	Close	Pass / Fail
Chamber # 1	33727	3,20	3.40 PSI	3:25	3.07 PSI	Pass
Chamber # 2 (Main Seam)	33725	4:10	3,50 PSI	4:20	3.24 PSI	Person

Chambers	Design				eakage Test	<del></del>			
	(closing) Fressure		Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail
# 1	3,07 PSI	3.25	3.25	2.70 PSI	25° 25°	29.83 29.64	-0.6931	a.60 PSI	Pass
# 2	2 a / PSI	411 -		PSI PSI				2 46 PSI	
(Main Seam)  Re-Test	3,24 131	4:20	4220	2.47 PSI	25 as	29.65	10.004	2.48 PSI	Pass

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	± 0.100 *	3,5	Fass	47.0	± 0.5	46 5/8	Cass	24.75	± 0.5	25 3/16	Pass
7.3	± 0.100 *	7.3	Pass	* = I	AW QSI 018, re	ev. A dated 03-05-29		31.0	± 0.5	31 3/8	Pasa

		Subm.Date / @ -pm	Pass/Fail	Subm.Date /am-pm	Pass/Fail	Subm.Date /@p-pm	Pass/Fail	Subm.Date / am-pm	Pass/Fail
- ee	24 hour	Feb 15/05	Pass	Jeh18 105	Pass	may 5/05	Puss		:
	7 day	Jeh 15/05	Pass	Feb 18/c5		may 5/05	Pass		
ear	24 hour	7en 15/05	Pass	7-28/8/05	Pues	may 5/05	Pass		
Sh	7 day	Feb 15/05	Pass	7-618/05	Puss	may 5/05	Pers		

Rev. D Sheet 1/3

**Description:** Float Bag Assembly 5/N: B21829-19

-Items are Manufactured IAW Process Control Specification No. 001, 002, 003, 004, 005, 006, and are to be 100% inspected I.A.W. P.I.P. 001

TSS P/N: 8927 Qty.: <u>1</u> Customer P/N: D3218-041 Dwg. No.: D3218 Rev.: A CM Cutting IAW PCS 003 Marking IAW PCS 004 **Bonding IAW PCS 002** Silkscreen Operator No. Date Operator No. Date Operator No. Date Operator No. Date Documented below

\* Note: PCS 006, there shall be a total of 2 samples submitted for the Testing of the Adhesive (Peel and Shear Test), at start and end of every production day, record on sheet 3/3

Stages & Descriptions	Operator No. 4 Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept	Insp. Stamp	Date _
<ul> <li>1- a) a) Attach Panel A (uneven edge) to larger edge of Panel B, centered on a 2" inner tape (butt joint)± 1/8"</li> <li>b) Attach (6) Valve Flanges on Panel A: 2-Relief, 2-Inlet &amp; 2- Topping Up</li> <li>c) Attach (6) Doublers on above Flanges</li> </ul>		Bonding						364-4662-644,6386646
2- a) Attach Panel C to Straight edge of Panel A, centered on a 2" inner Tape (butt joint) ± 1/8"								
3- a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape								
4- a) Baffle Ass'y. with 2" Tape ± 1/8"		D. A.						
5- a) Attach Baffle Ass'y. to Bag (in 3 stages, minimum)		Bonding						
6- a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time		Testing (see sheet 2)						
7- a) Closure of 1" Main Seam (overlap) ± 1/8" b) Attach ID Patch (ref. CAR 04-003)		Bonding						
8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time		Testing (see sheet 2)				:		
9- a) Attach 1" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8"					-			
b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bag		Bonding						
c) Attach 5" split patch on each end ( x 4 )		19.2						

Rev. D Sheet 2/3

Stages & Descriptions	Operator No. + Date		Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp. Stamp	Date*
10- a) Final Test							-	
b) Inspector to Stamp on ID Patch:		7		,		<del> </del>	1	
Serial No.: B 2 / 8 2 9 - 1 9	12	Testing (see sheet 3)	1			1		aug 16 2007
& Inspection Stamp beside the S/N		(300 anot. 3)	•					
Upon completion of the (final) leakage test, the ID Patch shall be stamped with 5/16 " hig	h lettering and black	cink: serial number (7 dig	its), provided b	y DART (refer	to W/O). *	Verify the integ	rity of the Val	ves (Threads/gaskets).

Test Conditions – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

#### Baffle Test:

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams.

Inflation Test: Lower Chamber to 3.00 psi, re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 294PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase + 0.049 PSI for each 0.1 inch of barometric increase

- + 0.054 PSI for each 1°C of temperature decrease
- ase 0.049 PSI for each 0.1 inch of barometric decrease

Chambers	Pressure	5 Min. Over P. & Soap Test	H	45 Minute bilizing Per						1	Hour Test			
Citambers	· ·	Pass / Fail	Design Pressure (wa ta /a)	Time On	Time Off	Design Pressure	Time On	Time Off	Read'g	Temp. . Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail
# 1 (see note 1)	4.36 PSI		3.00 PSI	10:45	11:30	3.00 PSI	11:30	12:30	3.00 PSI	25 25	2977 2977	-	3.00 PSI	Con
Re-Test														
# 2 (Main Seam)	4.36 PSI		PSI	8:30	9:15	3.00 PSI	9:20	10'20	3.00 PSI	23 23	29.75 29.75		3.08 PSI	fess
Re-Test														

Note 1: Chamber # 1 requires Dart Aerospace Approval Signature:	Na	Date:	
Observations:		·	

original 5/F 3664 5/020153

# TULMAR #6

SINI B21829-19

# Product Inspection Form # 193-8927(Tube & Final)

Rev. D Sheet 3/3

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3:—3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2):

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the

Pressure Relief Valve Test	DDV 6 : 13		ning	Clos	ing hung	. <i>33%</i>
Chamber # 1	PRV Serial Numbers	Time ON	Pressure	Time	Close	Pass / Fail
Chamber # 2 (Main Seam)	33178	12:15	3.24 PSI 3.76 PSI	10:45	3.05 PSI	fiss
		104115	$3.7\varphi$ rsi	10,20	3,00 PSI	tass

Chambers	Design (closing) Pressure		24 Hour Leakage Test									
aug 1307	as per above	Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail			
# 1 Re-Test	3,05 PSI	10:45	10145	2.48 PSI	<i>эч 3</i> 3	29.74 29.86	0.058	2.59 PSI	Cos			
(Main Seam)  Re-Test	3.00 PSI	12:30	12:20	1.96 PSI	23 23	29.86 29.63	0.113	1.79 PSI	fiss			

Dim.	Tol. ± 0.100.*	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
7.3	± 0.100**			47.0	± 0.5		,	24.75	± 0.5		
			L	* = IAW	<sup>7</sup> QSI 018, re	v. A dated 03,05-29	16	31.0	± 0.5		

L			Subm.Date / am-pm	Pass/Fail	Subm.Date / am-pm	Pass/Fail	Subm.Date / am-pm	Pass/Fail	Subm. Date / am-pm	Pass/Fail
İ	set	24 hour			·	2	•		pm	1 435/1 411
	<u>a</u>	7 day				NIO		,		
	ar	24 hour				N/a.				
	She	7 day			`					

Rev. D. Sheet 3/3

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 - 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

	Pressure Relief	,	O	pening	Clos	ing	
	Valve Test	PRV Serial Numbers	Time ON	Pressure	Time	Close	Pass Fail
	Chamber # 1	33204	11:40	3.50 PSI	11:45	3,10 PSI	fass
d	Chamber # 2 (Main Seam)	33/78	12:00	3.27 PSI	12:05	3.07 PSI	Pass

Chambers	Design				24 Hour U	eakage Test			
Chambers	(closing) Pressure as per above	Time On	Time Off Read'g		Temp. Start/End	Barom. Start/End	Adjust.	Final Read g	Pass Fail
Rc-Test  ###	3.10 PSI	11:45	11:45	2. PSI PSI	A3 C 23 C	29.74 29.94	+0.098	2.09 PSI	Poss
(Main Scam)	3.:07 PSI	12:05	12:05	2,58 PSI	23 <sup>c</sup> 23	29.93 29.41	20.384	ત્રે.3૨ PSI	Pasa

	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
إلى	3.5	± 0.100 *	3.5	Pass	47.0	± 0.5	47	1800	24.75	F 0.5	25 1/4	Fass
	7.3	± 0.100 *	7.5/16	Coss	* = IAW	OSI 018, rev	v. A dated 03-05-29	^ )	31.0	1.0.5	31 1/2	fusa
Ţ			•				,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	( M /				

		Subm.Date / affipm	Pass/Fail	Subm.Date / am-pm)	Pass/Fail	Subm.Date / amເpົ້ານັ່ງ	Pass/Fail	Subm.Date / am-pm	Pass/Fail
l se	24 hour	Dec. 6. 104	Pass	Dec 6/04	Place	Dec 20/04	Jusa		
	7 day	Declos	Pass	Rackloy	Ouss	Dec20/04	Piss		
i i	24 hour	Decloy	Pass	Que 6/04	Paga	Dec 20/04	Duss		
She	7 day	Deck loy	Pusa	Rec6/04		1Dec 20/04	Posa		

CMAR #6

### **Product Inspection Form # 193-8927(Tube & Final)**

Rev. D. Sheet 23

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qtv.	NCR	Total Accept.	Insp. Stamp	Date
10- a) Final Test b) Inspector to Stamp on ID Patch: Serial No.: B & Inspection Stamp beside the S/N	12 Dx C23/04	Testing (see sheet 3)	1			. (	A	Dec 23/04

expose completion of the Critical reaction with Section 11 and black in the completion of the Valves (Threads gaskets) and black in the completion of the Valves (Threads gaskets)

Test Conditions – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

#### Baffle Test:

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams. Inflation Test: Lower Chamber to 3.00 psi, re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase
- + 0.054 PSI for each 1°C of temperature decrease
- + 0.049 PSI for each 0.1 inch of barometric increase
- 0.049 PSI for each 0.1 inch of barometric decrease

Chambers	Pressure	5 Min Over P. & Soap Test	1	45 Minute bilizing Per			I Hour Test									
		Pass / Fail	Design Pressure	Time On	Time Off	Design Pressure	Time On	Time Off -	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail		
# 1 (see note 1) Re-Test	4.36 PSI	Pass	3.00 PSI	10:35	<u> </u>	3.00 PSI	<b>॥</b> ः२०	13:30	<b>3.98</b> PSI	33° 23°	29.73 29.10	-0.009	2.97 PSI	Pass		
Dec 16 2004 (Main Seam) Re-Test	4.36 PSI	Pass	3.00 PS1	///3e	12:15	3.00 PSI	12:15	1:15	2.96 PSI	23 23	29.81 29.79	20,009	<b>2.9</b> \$ PSI	Pass		

Note 1: Chamber # 1 requires Dart Acrospace Approval Signature: Chan Pros	Date: 04.12.10
Observations: One area on insule siem to be pressed down /g/wed.	Otherwise OK. LABEL NOW 13" WIDE TO COVER SURPACE
	BLEMISH 10 -117

TULMAR

# Product Inspection Form # 193-8927(Tube & Final)

Rev. D. Sheet 1.3

**Description**: Float Bag Assembly

-Items are Manufactured IAW Process Control Specification No. 001, 002, 003, 004, 005, 006, and are to be 100% inspected I.A.W. P.I.P. 001

TSS P/N: 8927 Qty.: 12 Customer P/N: <u>D3218-041</u> Dwg. No.: <u>D3218</u> Rev.: A Date: <u>Hec 2004</u>

Cutting IAW PCS 003		Marking	IAW PCS 004	Bondi	ing IAW PCS 002	Silkscreen			
Operator No.	Date	Operator No.	Date	Operator No.	Date	Operator No.	Date		
				<u>  ( Docui</u>	nented below)				

<sup>\*</sup> Note: PCS 006, there shall be a total of 2 samples submitted for the Testing of the Adhesive (Peel and Shear Test), at start and end of every production day, record on sheet 3/3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total Accept.	Insp.	Date
	57 6 dec. 04	7104-25	1	*		/ \	250	Dec. 6/04
centered on a 2" inner tape (butt joint)± 1/8" b) Attach (6) Valve Flanges on Panel A:	37 2dec 04		6			6	(11)	Dee2/04
2-Relief, 2-Inlet & 2- Topping Up c) Attach (6) Doublers on above Flanges	37 2dec 04	Bonding	6			Q	(58)	Dec 2/04
2- a) Attach Panel C to Straight edge of Panel A, centered on a 2" inner Tape (butt joint) ± 1/8"	37 6 dec .04	7104-25	l			/	(9)	Dec. 6/04
3- a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape	37, 6 dec .04		/			. (		Dec. 6/04
4- a) Baffle Ass'y, with 2" Tape ± 1/8"	117 deco4	D!:	/	~		/	TUY XOS	Dec 6/04
5- a) Attach Baffle Ass'y, to Bag (in 3 stages, minimum)	111 7dec04	Bonding	1			/		Doe 7/04
6- a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time	Dec 10/2004	Testing (see sheet 2)	)		_	l		Dec is/oy
7- a) Closure of 1" Main Scam (overlap) ± 1/8"	37 13 dec. 04	7104-26 Bonding	1			/	(73)	Dec 13/04
b) Attach ID Patch (ref. CAR 04-003)	117 21 decot	Dollaing .			***************************************			Jan 10/04
8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time	16 dec 2004	Testing (see sheet 2)	1			1	(15 s)	Dec 16/04
9- a) Attach 1" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8"	٠, , , , ,	"/104-26	1		_	/ (		Dee21/04
b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bag	117 20 dec	Bonding	/			1	(A)	Nee21/04
c) Attach 5" split patch on each end (x 4)	117 20devo4	4	/				777	Noe 21/04

c) Attach 5" split patch on each end (x4)

# **Product Inspection Form # 193-8927(Tube & Final)**

Rev. D Sheet 1/3

Description:	Float Bag	Assembly	S/N:	B21	829-	20

-Ite	ms are Manufactured IAW 1	Process Control Spe	ecification No. 00	01, 002, 003, 004	, 005, 006.	and are to	be 100	1% inspecte		P I P 101
2.0 HA	0/53 TSS P/N: 89		Customer P/N:		Dwg. No	· · · · · · · · · · · · · · · · · · ·	Rev.:	A Date		
	Cutting IAW PCS 003	Marking I	AW PCS 004	Ron	ding IAW	PCS 002		C SML	Silkscre	
Operator 1	No. Date	Operator No.	Date	Operator No		Date		Operator No.	Siikscre	Date
				- Operator No	-	Date		Operator No.	<del> </del>	Date
				( Doci	unentec	below	7			<del></del>
				1 2000	<del>AIII OII CO</del>	1 OCIOVY	<del>/</del>		<del> </del>	
* Note: PC	S 006, there shall be a total of 2 s	samples submitted for	the Testing of the	Adhesive (Peel and	Shear Test	), at start ai	nd end of	f every produ	ction day.	record on sheet 3/3
	& Descriptions		Operator No. + Date	Operation	Accept. Qty.	Reject.	NCR	Total Accept.	Insp.	Date
b) Atta 2-R c) Atta 2- a) Att	Attach Panel A (uneven edge) to la tered on a 2" inner tape (butt joint) ach (6) Valve Flanges on Panel A: elief, 2-Inlet & 2- Topping Up ach (6) Doublers on above Flanges each Panel C to Straight edge of "inner Tape (butt joint) ± 1/8"	)± 1/8"		Bonding				·		
3- a) Att	. Panel D to Panel B (shorter edg	e) with 2" inner Tape								
4- a) Ba	ffle Ass'y. with 2" Tape $\pm 1/8$ "	· /								
5- a) Att	each Baffle Ass'y. to Bag (in 3	stages minimum )		Bonding						, i
6- a) Peri	form Baffle Test on Chamber # 1	ifter a 3 day Cure Time	•	Testing (see sheet 2)						
	osure of 1" Main Seam (overlap each ID Patch (ref. CAR 04-003			Bonding						
8- a) Perf	form Baffle Test on Chamber # 2 a	after a 3 day Cure Time		Testing (see sheet 2)						
Se	ach 1" wide Finishing Tape on ram, Centered ± 1/8" t. Inspected Girt Ass'y. (Form 1			Bonding		·				

Rev. D. Sheet 2/3

Date	Insp. Stamp	Total Accept.	NCR	Reject. Qty.	Accept. Qty.	Operation	Operator No. + Date				otions	ages & Descrip
	631											a) Final Test
rug 16 2007	9 22					Testing	_			D Patch:	tamp on I	b) Inspector to Sta
σ		ł			1	(see sheet 3)	12		20	29-2	218	Serial No.: B
	•	·	; 		-				N	de the S/N	tamp besi	& Inspection St
_ (1	rity of the Valy	Verify the integr	to W/O). * 1	ov DART (refer	gits), provided b			with 5/16 " high	N	de the S/N	tamp besi	•

**Test Conditions** – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C ± 5°C c) Relative humidity shall be 80 % or less

#### **Baffle Test:**

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams. Inflation Test: Lower Chamber to 3.00 psi, re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase

+ 0.054 PSI for each 1°C of temperature decrease

+ 0.049 PSI for each 0.1 inch of barometric increase

- 0.049 PSI for each 0.1 inch of barometric decrease

Chamban	D	5 Min. Over P. & Soap Test	lt .	45 Minute bilizing Per	1					1 Hc	our Test			
Chambers	Pressure	Pass / Fail	Design Pressure aug 10/07	Time On	Time Off	Design Pressure	Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail
# 1 (see note 1)	4.36 PSI		3.00 PSI	1050	11:35	3.00 PSI	11:35	12:35	300 PSI	25 25	29.77 29.77		3.00 PSI	Pass
Re-Test			aug13/67		•									
# 2 (Main Seam)	4.36 PSI		3.00	8:30	9:15	3.00 PSI	9:20	10:20	3.00 PSI	23 23	29.75 29.75	-/-	3.00 PSI	Essi
Re-Test														

Note 1: Chamber # 1 requires Dart Aerospace Approval Signature:	Na	Date: <u>\(\sigma\)</u>
Observations:	I	

5/0 20153

# JLMAR # 10

# Product Inspection Form # 193-8927(Tube & Final)

Rev. D Sheet 3/3

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 - 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2). The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

Pressure Relief		C	pening		Clos	sing	humy 33%	ĭ
Valve Test	PRV Serial Numbers	Time ON	Pressure		Time	Close	Pass / Fail	
Chamber # 1	33203	10:30	3,45	PSI	10:35	3.13	PSI Pass	7
Chamber # 2 (Main Seam)	33181	12:10	3.86	PSI	12:15	3.01	PSI Pasa	].

Chambers	Design		24 Hour Leakage Test									
13/01 وينه	(closing) Pressure as per above	Time On	Time Off	Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Read'g	Pass / Fail			
# 1	3.13 PSI	10:35	10:35	2.53 PSI	<i>34"</i> 23"	29.74 29.86	0.054 To.058	2.64 PSI	Casa			
(Main Seam)	3.01 PSI	12:15	12:15	2.25 PSI	03 23	29.86 29.63	0.112	2.14 PSI	foss			
Re-Test									•			

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual	≀im.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	± 0.100 *			47.0	± 0.5				24.75	± 0.5	***	
7.3	± 0.100 *			* = IAV	V QSI 018, re	v. A dated 03-	05-29		31.0	± 0.5		

·		Subm.Date / am-pm	Pass/Fail	Subm.Date / am-pm	Pass/Fail	Subm.Date / am-pm	Pass/Fail	Subm.Date / am-pm	Pass/Fail
	24 hour				\				
a	7 day					N/a.	1/1/1		·
ar	24 hour					\			
She	7 day						-		

TULMAR	TUL	M	AK	)
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Rev.	D)	Sheet	1 3

**Description**: Float Bag Assembly

-Items are Manufactured IAW Process Control Specification No. 001, 002, 003, 004, 005, 006, and are to be 100% inspected LA.W. P.I.P. 001

TSS P/N: 8927

Qty.: **1**2 Customer P/N: <u>D3218-041</u>

Dwg. No.:D3218

Rev.: A

Date:

Cutting IAW PCS 003		Marking IAW PCS 004		Bond	ing IAW PCS 002	Silkscreen		
Operator No.	Date	Operator No.	Date	Operator No.	Date	Operator No.	Date	
		·		(Docui	nented below)			

\* Note: PCS 006, there shall be a total of 2 samples submitted for the Testing of the Adhesive (Peel and Shear Test), at start and end of every production day, record on sheet 3/3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject, Qty.	NCR	Total Accept.	Insp. Stamp	Date
1- a) a) Attach Panel A (uneven edge) to larger edge of Panel B, centered on a 2" inner tape (butt joint)± 1/8"	37 Tolic .C4	7104 26	1	a sa		/	(SS)	Dec 7/04
b) Attach (6) Valve Flanges on Panel A:	#110 2/13/04 \	Bonding	4. (c	and a second	( )	<i>ئ</i> ئ		>62.6/04
2- a) Attach Panel C to Straight edge of Panel A, centered on a 2" inner Tape (butt joint) ± 1/8"	37 7 dec .04	7104-26	1			<i>j</i> .	15.0X	Dec 7/04
3- a) Att. Panel D to Panel B (shorter edge) with 2" inner Tape	37 7dec.04	7104-26	/			/		Dec 7/04
4- a) Baffle Ass'y, with 2" Tape ± 1/8"	117 7 de é of		1	Carriera.	,	<i>j</i> ·	130	Dec 7/04
5- a) Attach Baffle Ass'y, to Bag (in 3 stages, minimum)	117 8 deco4.	Bonding	,			1	(So)	Dec 8/04
6- a) Perform Baffle Test on Chamber # 1 after a 3 day Cure Time	/2	Testing (see sheet 2)	,	-			235	
7- a) Closure of 1" Main Seam (overlap) ± 1/8"	Jan 6/05 Jan-13/05	7104-28			-	·`\	(As)	Jan 6/05
b) Attach ID Patch (ref. CAR 04-003)	3 fu-105	Bonding	1			1	14	Feb4105
8- a) Perform Baffle Test on Chamber # 2 after a 3 day Cure Time	Jan 18/05	Testing (see sheet 2)				j	(4)	jan 18/05
9- a) Attach I" wide Finishing Tape on all Butt Joints & Main Seam, Centered ± 1/8"	1 37	7104-28	/			/	117	Leb 4/05
b) Att. Inspected Girt Ass'y. (Form 193-8927, Girt) to Bag	3 fur. 05	Bonding	/		-	1		11 11 11
c) Attach 5" split patch on each end $(x 4)$ 37	Bfw.05	7104-28	1			/ (	717	Feb 4105

LMAR # 10

# Product Inspection Form # 193-8927(Tube & Final)

Rev. D. Sheet 2.3

Stages & Descriptions	Operator No. + Date	Operation	Accept. Qty.	Reject. Qty.	NCR	Total	The second secon	Date
10- a) Final Test b) Inspector to Stamp on ID Patch:	12 Feb 9/05	Testing	1			/	A	Feb 9/2005:
Serial No.: B		(see sheet 3)						
& Inspection Stamp beside the S/N	·						]	
Upon completion of the (final) leakage test, the ID Patch shall be stamped wit	th 5/16 " high lettering and black	ink: serial number (7	digits), provided	th DARLOG	r to W/O),	A Verify the in	tegrify of the S	alves (Threads/gaskets), 1

Test Conditions – All tests shall be performed in the following conditions:

a) Atmospheric pressure between 28 to 32 inches of mercury (94.8 kPa to 108.4 kPa) b) Temperature shall be 20°C 4.5°C e) Relative humidity shall be 80 % or less

#### Baffle Test:

Over Pressure: Using socket tool and torque wrench s/n 0801300327, tight all (3) Valves to 40 inch pound, the JIC adaptor s/n 44537 between 15 to 20 foot pounds. Block the Relief valve with flagged pin. Inflate Chamber to 4.36 PSI (30 kPa) with clean dry air source. Using leak detector or non detergent soap, check all the valves and seams to detect leakage. Leakage shall be cause for rejection (soap during testing period). Fuzz is not considered a failure. After 5 minutes, there shall be no evidence of distortion or damage to the seams.

Inflation Test: Lower Chamber to 3.00 psi, re-adjust after 45 minutes. After 1 hour, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period. The corrected pressure reading shall not be less than 2.94PSI in order for the Test to be acceptable.

- 0.054 PSI for each 1°C of temperature increase

- 4-0.054 PSI for each 1°C of temperature decrease
- + 0.049 PSI for each 0.1 inch of barometric increase
- = 0.049 PSI for each 0.1 inch of barometric decrease

Chambers	Processo	5 Min. Over P. & Soap Test	ļ	45 Minute Stabilizing Period			1 How test hury 6 %								
Chailibers	Pressure	riessure	Pass / Fail	Design Pressure	Time On	Time Off	Design Pressure	Time On	Time Off	. Read'g	Temp. Start/End	Barom. Start/End	Adjust.	Final Readig	Pass Tail
#   (see note 1)	4.36 PSI	Pass	3,00 PSI	12:15	1:00	3.00 PSI	1:00	2100	<i>⊋. 99</i> PSI	22 32	29.72 29.63	-0.044	2.95	Cass	
Rc-Test	·														
# 2 (Main Scam)	4.36 PSI	Pass	3.00 PSI	2:15	3:05	3.00 PSI	3:05		2.97 PSI	19 19	30.51 30.53	10,009	2,98 PSI	Pass	
Re-Test															

Note 1: Chamber #	1	requires	Dart	Acrospace	/	Approval	Si	gnati	urc

: Ches Provenu

Date: 05.01.12

Observations: OK. Has I" dien police on before, OK.

Rev. D. Sheet 3/3

Final Test: Leakage / Relief Valves: The chambers are to be tested separately (one at a time). Through the Topping Up Valve, inflate chamber to approximately 2.00 PSI, soap the (3) valves to detect leakage. Then slowly inflate chamber until pressure relief valve vents. Use leak detector or non detergent soap to detect the opening and the closing. A hissing sound may also denote that the valve has started to open. Record the opening/closing time and pressure. The opening pressure shall be between 3.3 – 3.5 PSI and the closing pressure shall not be less than 3.00 PSI, in order for the test to be acceptable. After 24 hours, take the pressure reading of the chamber. Compensate the pressure reading by allowing for any temperature and barometric pressure changes during the test period (see sheet 2).

The corrected pressure reading shall not be less than 1.60 PSI in order for the Test to be acceptable.

Upon completion of the Final Test, inflate both chambers equally to approx. 2.00 PSI and perform Dimensional Verification below. Perform additional inspection of the tapes and girt assembly.

<b>i</b>				parameter and the second of the second of the second of the second of the second of the second of the second of	The second secon	
Pressure Relief	•	Opc	ening	Clos	Pass / Fail	
Valve Test	PRV Serial Numbers	Time ON	Pressure	Time	Close	7 7
Chamber # 1	33203	9:55	3.45 PSI	10:00	3.01 181	food
Chamber # 2 (Main Seam)	23/8/	10:40	3, 50 PSI	10:45	3.0 181	fass!

	Design		24 Hour Leakage Test									
Chambers Feb 1/65	(closing) Pressure as per above	Time On	Time Off	Read`g	Temp. Start/End	Barom. Start/End	Adjust	Final Read'g	Pass Fail			
# 1	3.01 PSI	10:00	10:00	2.80 PSI	<i>ब</i> र बन	30,12 29.82	-0,147	2.65 PSI	Pass			
Re-Test												
(Main Scam)	3. 0 PSI	10:45	10:45	2.19 PSI	22 22	29.80 29.85	+0.034	2.21 PSI	Pages			
Re-Test												

Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail	Dim.	Tol.	Actual Dim.	Pass/Fail
3.5	± 0.100 *	211	0	47.0	± 0.5	44.505M.	Coos	24.75	+ 0.5	253/8	fass
73	± 0.100 *	7.4	Pasa				6250	31.0	: 0.5	31 1/8	Pers
L	1 2 0.100	1,7	1 1442	, = IV	w Q51 018, re	v. A dated 03-05-29		ţ		,	

		Subm.Date / am 🏟	Pass/Fail	Subm.Date / am-หูเพิ	Pass/Fail	Subm.Date /am-pm	Pass/Fail	Subm.Date / am-pm	Pass/Fail
<u>-</u>	24 hour	Buc 7/04	Pasa	Dec 9/04	Pass	Jan 13/05	Pass		
ا م	7 day	Dec 7/04	Pass	Dec 4/04	Pass	Jan 13/05	Pass		
ı,	24 hour	Dec7/04	Pass	Dec 8/04	Pass	Jan 13/05	Puss		
She	7 day	Dec 7/04	Pass	Dec 8/04	Pars	Jun 13/05	Pass		